



**JK- 6320
6320cx**

User Guide

**INSTRUCTION BOOK
PARTS CATALOGUE**



MIPECA SERV
MASINI DE CUSUT INDUSTRIALE



JACK SEWING MACHINE

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Operation instruction

Notice:

1. Parts design is subject to change without notice.
2. Only the professional can adjust and repair the machine except adjusting stitch length.

1. Main technical specifications

Application: medium and heavy duty (JK-6320CX heavy duty with thick thread)

Max sewing speed: 2000spm (JK-6320CX 1800spm)

Stitch length: 0-8mm

Presser foot lift: 6.5mm by hand 13mm by knee

Max sewing capacity: 8mm

Alternate presser foot lift volume: 2.5-3.5mm

Timing feed length: not less than 8mm

Needle: Model DPx17 20#~24# (JK-6320CX DPx17 25#)

Hook: Auto-lubricating big rotating hook

Lubrication: Auto lubrication

Motor power: 0.37kw

2. Preparation

(1) Cleaning machine

Clean off the grease and dusts on the surface of machine with gasoline and soft cloth.

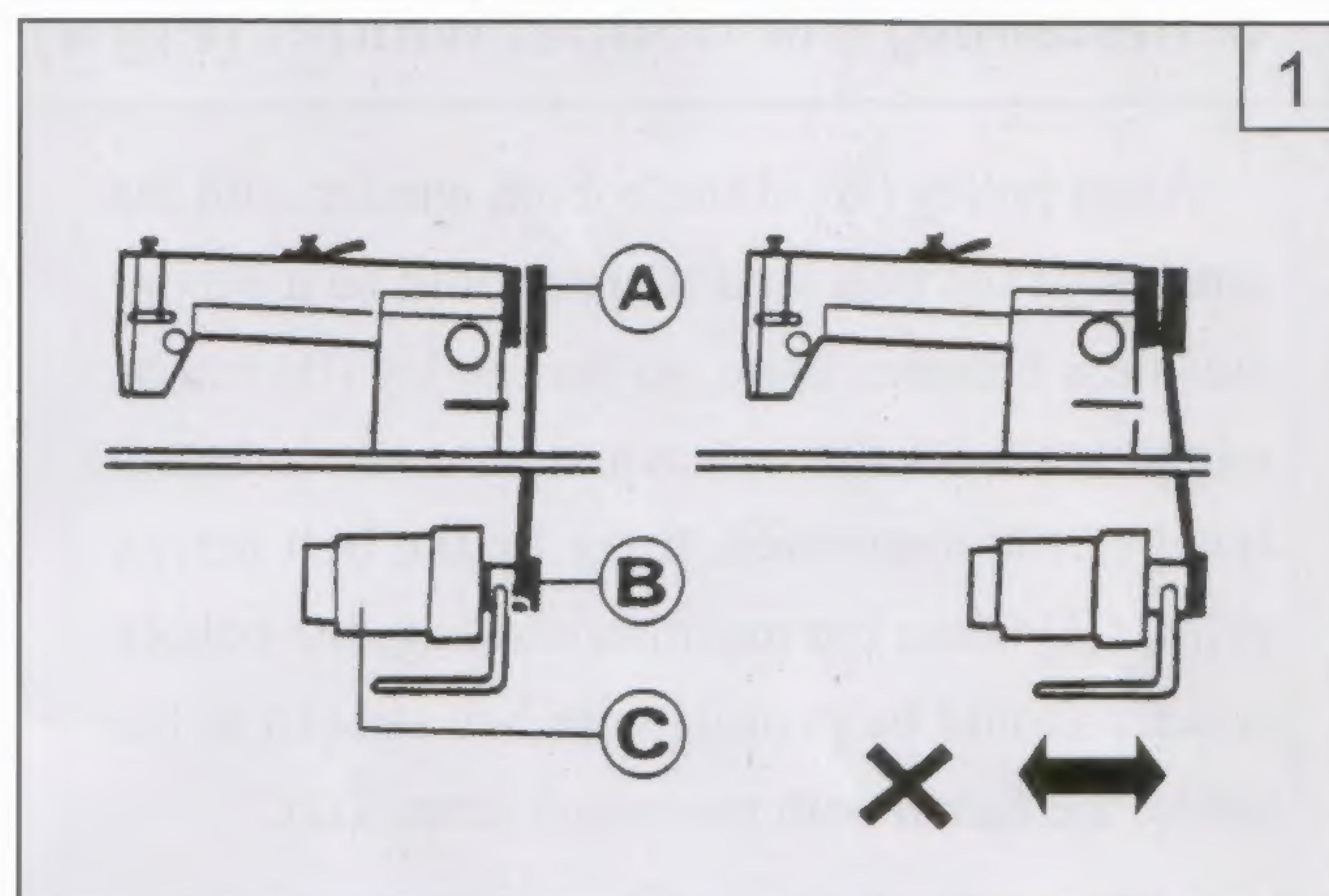
(2) Inspection

Before use a thorough inspection should be done up on the machine. Turn balance wheel slowly to see if there is any obstacle, collision and uneven resistance between parts.

If there is, adjustment should be done before operation.

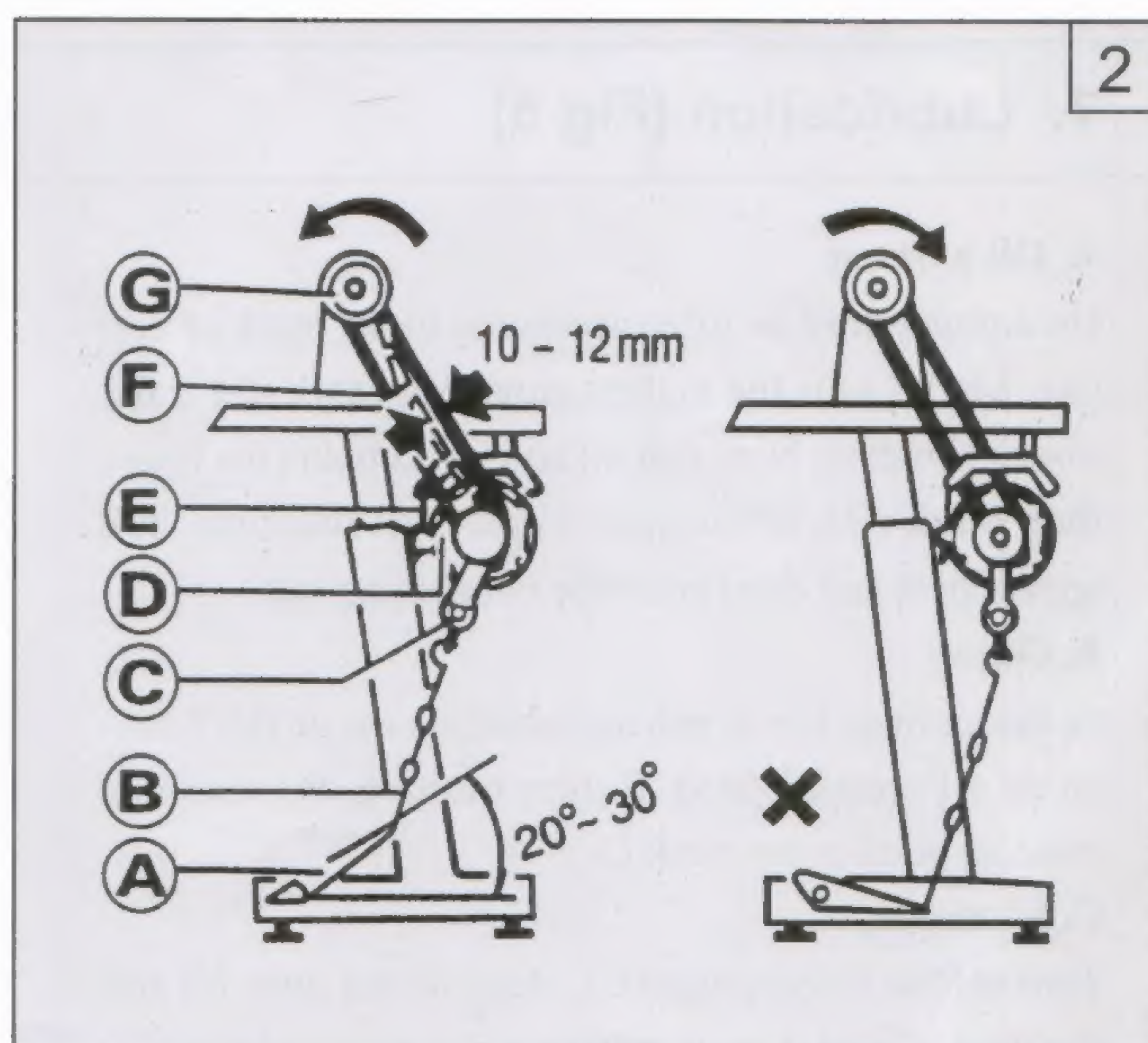
3. Installing the motor (Fig.1)

Align machine balance wheel belt groove (A) with motor pulley belt groove (B) by moving the motor (C) leftward or rightward. Be sure the belt is not louch with table.



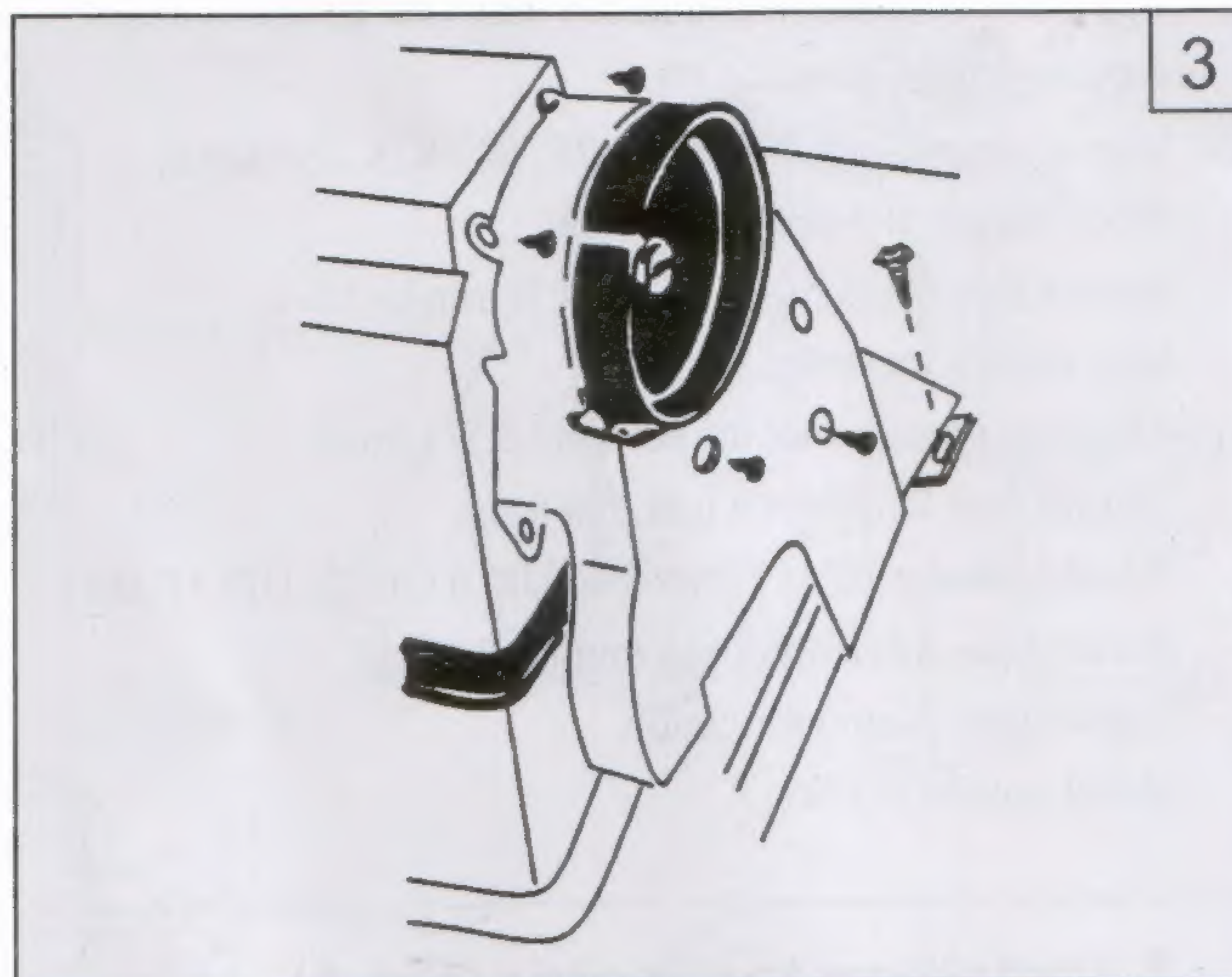
4. Connecting the clutch lever to the pedal (Fig.2)

- The optimum tilt angle of pedal with floor is approx 15 degree.
- Adjust the clutch of the motor so that clutch lever (C) and draw bar (B) run in line as Fig.6, the machine would have stable motion and long using.
- The machine balance wheel should rotate counter clockwise for normal sewing when view from opposite side of the balance wheel. The motor rotates in the same direction. The rotation can be reversed by reversing (turn over 180 deg.) the plug of the motor.
- Adjust the tension of V-belt F by moving the motor vertically. The proper tension of V-belt is a slack of 10-12mm when the belt is depressed (at the belt pan) by finger.



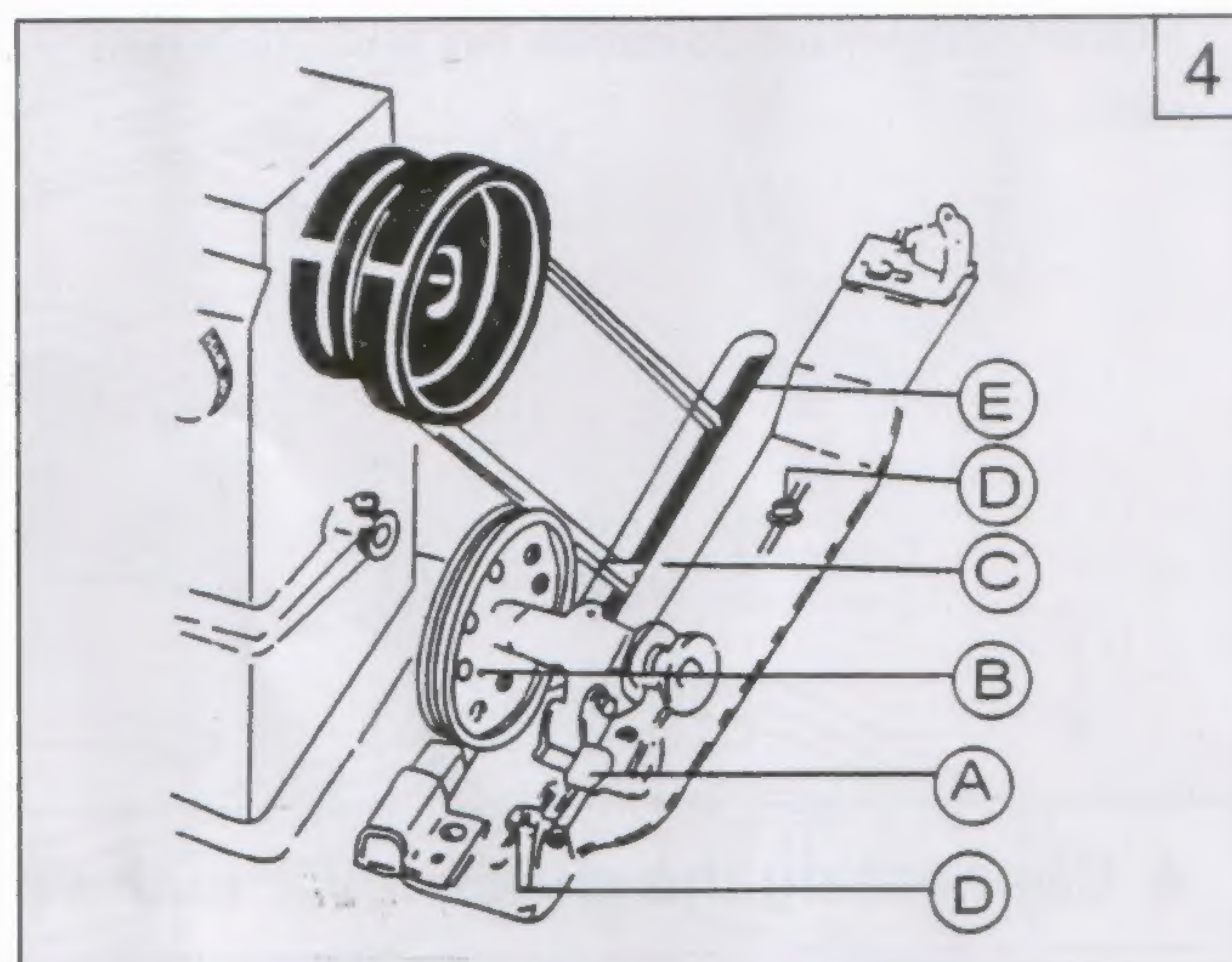
5. Installing belt guard (Fig 3)

The belt guard should be installed for safety.



6. Installing the bobbin winder (Fig 4)

Align pulley (B) of the bobbin winder with the outside of the belt, and there should be a proper cleanness between them, so that pulley (B) can be contacted with the belt when stop latch thumb lever (A) is depressed, there by the belt drives pulley (B) while the machine running, the bobbin winder should be parallel with belt slit (E) of the table, then fasten with two wood screws (D).



7. Lubrication (Fig 5)

A. Oil amount

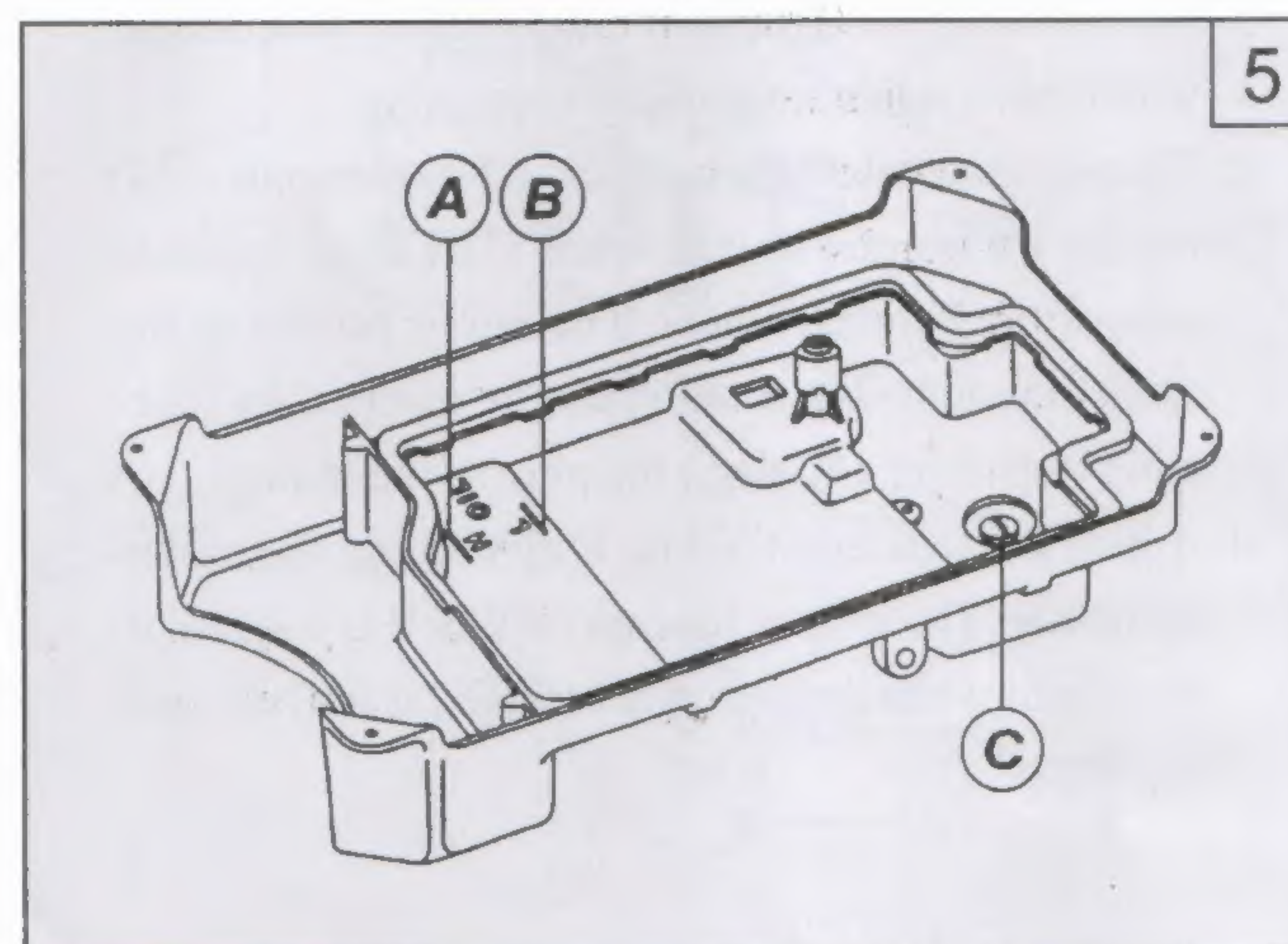
Oil amount must be oiled according to the mark of drip pan, Mark (A) is the highest situation, Mark (B) is the lowest situation, Note that oil amount couldn't be lower than mark (B), otherwise all parts of machine will appear heat and dead point for not gaining oil.

B. Oiling

In lubrication, HA-8 sewing machine oil or HJ-7 machine oil must be used. Before running, the machine must be oiled at the mark (A).

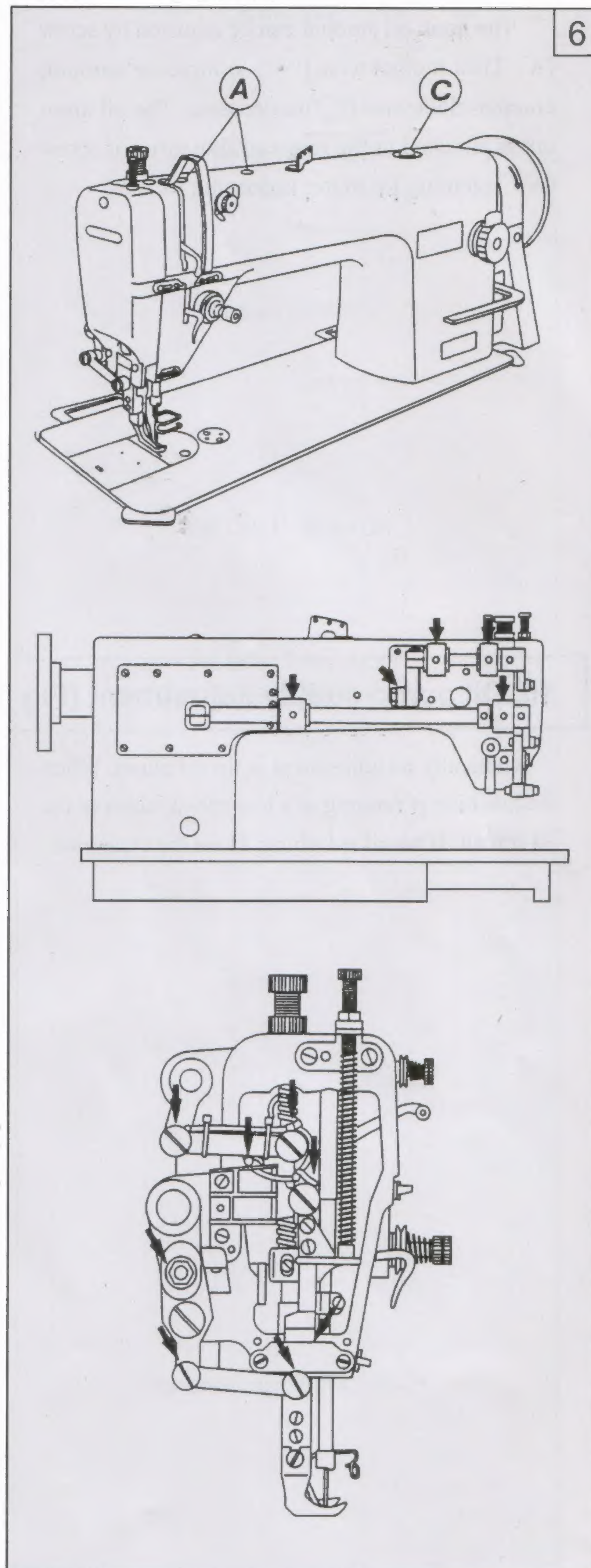
C. Changing

Turn off the screw plugs (C), clean up the dirty oil and the dust of drip pan, then fasten the screw plugs (C), add fresh oil.



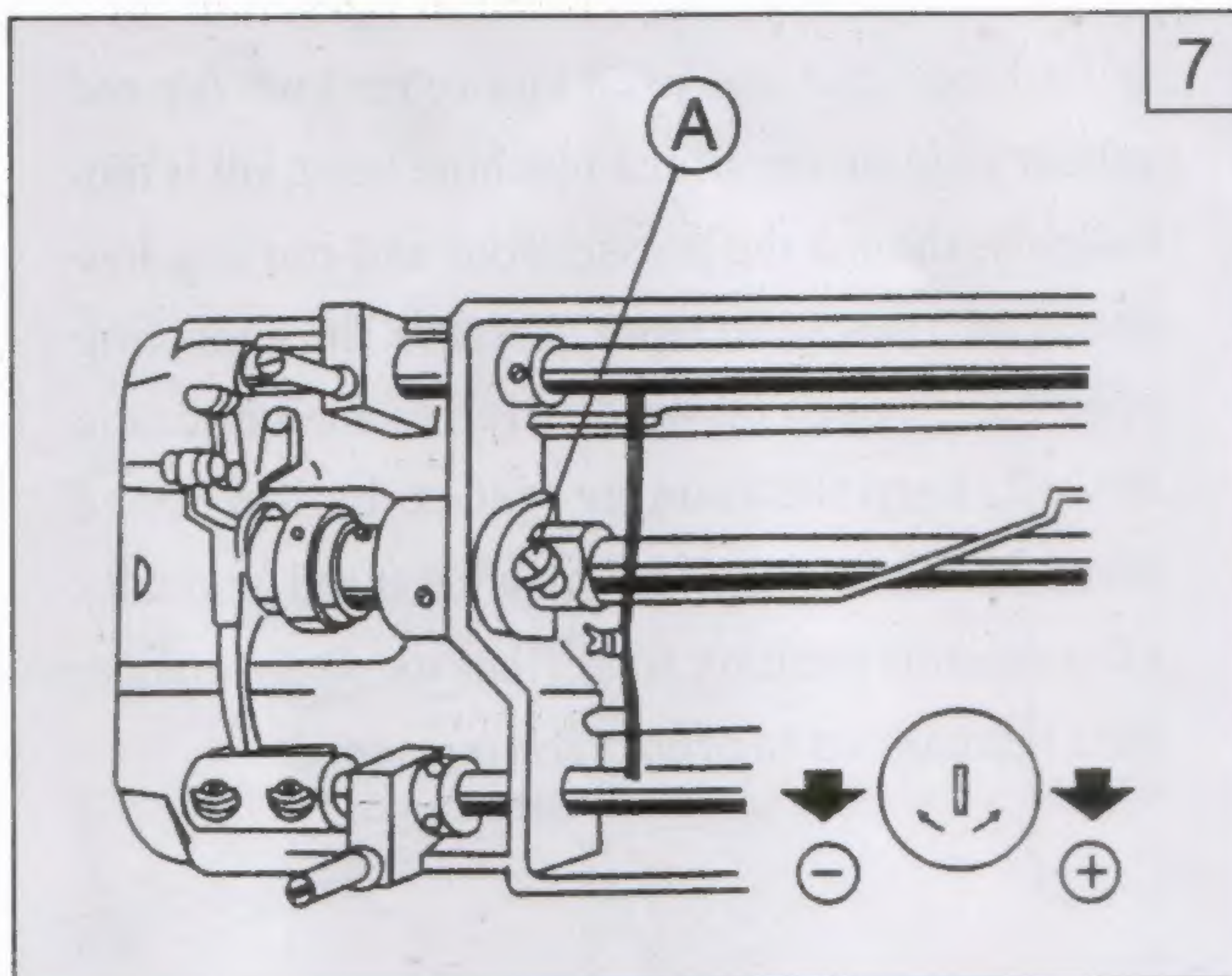
8. Trial run (Fig 6)

When the machine left out of operation for a quite long time and used again, remove the red rubber plug on top of the machine head, oil it thoroughly, then lift the presser foot and run at a low speed of 1000~1500spm, observe the sparkling condition through oil window (c), as the lubrication is well, keep the running test at the low speed about 30 minutes, then increase the speed gradually, after months running to perfect its performance, then increase up to proper sewing speed.



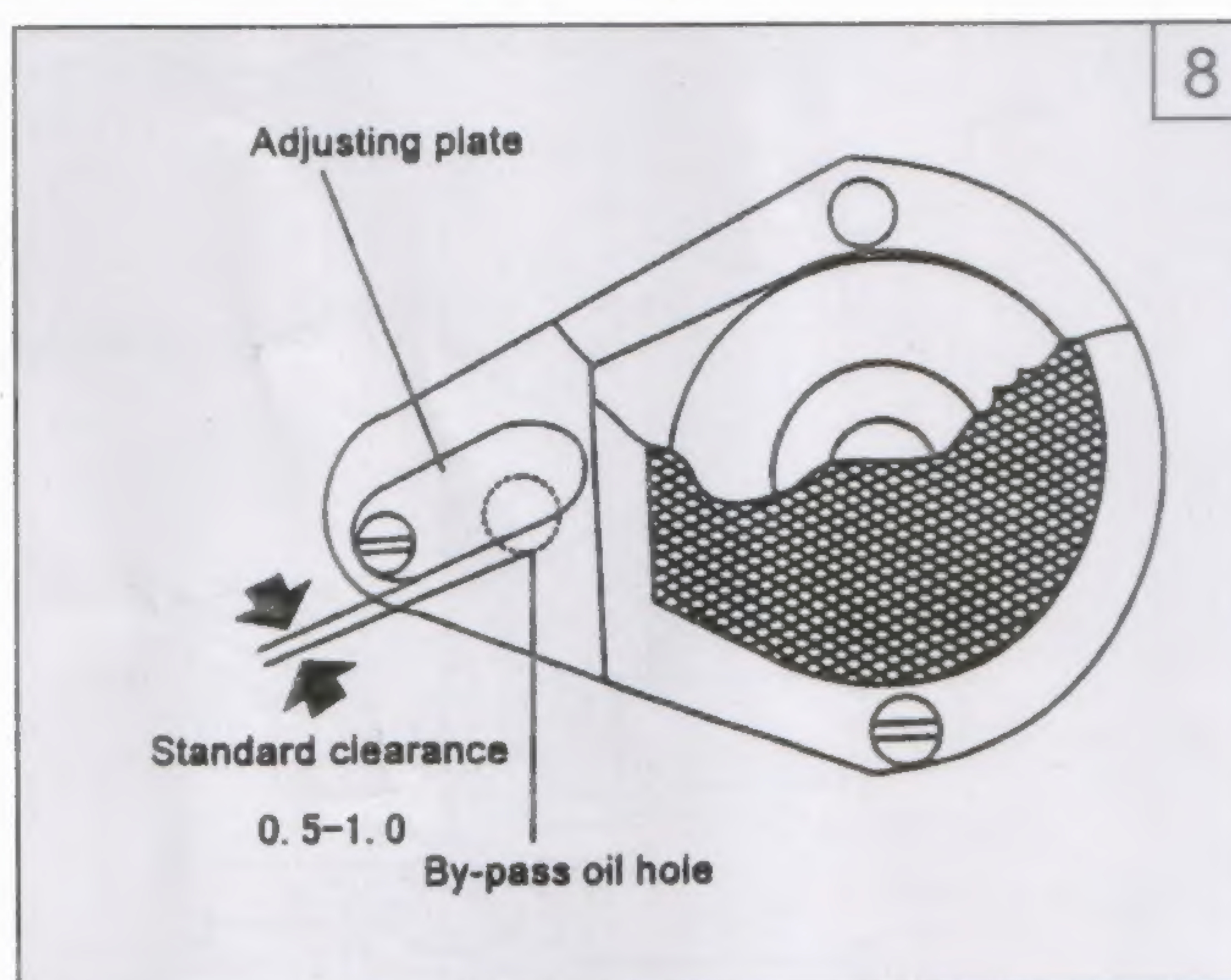
9. Rotating hook oil amount adjustment (Fig 7)

The hook oil amount can be adjusted by screw (A). Turn it clockwise ("+") to increase amount; counter-clockwise ("-") to decrease. The oil amount is adjusted in the range of five turns of screw (A): Tightning for more; Loosening for less.



10. Oil pump supply adjustment (Fig 8)

Generally no adjustment is for oil pump, When the machine is running at a low speed, observe the oil screen. If no oil splashing, close the clearance.

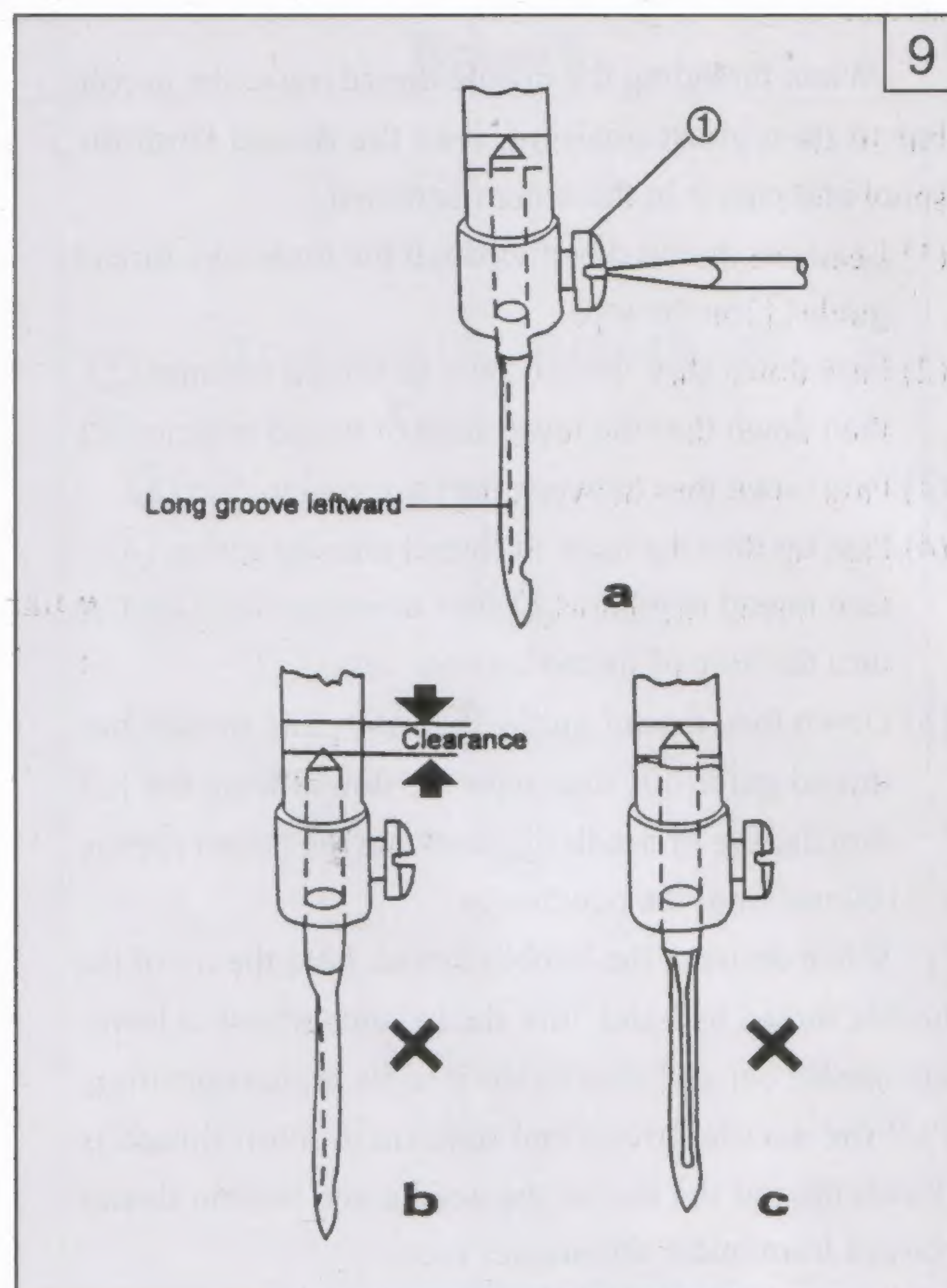


11. Installing the needle (Fig 9)

Turn the balance wheel to lift the needle bar to its highest point, loosen needle set screw 1, making the needle groove turn to the left side of an operator, fully insert the needle shank up to the bottom of needle socket, then tighten needle set screw 1.

Note: Fig.12(b) insufficient insertion.

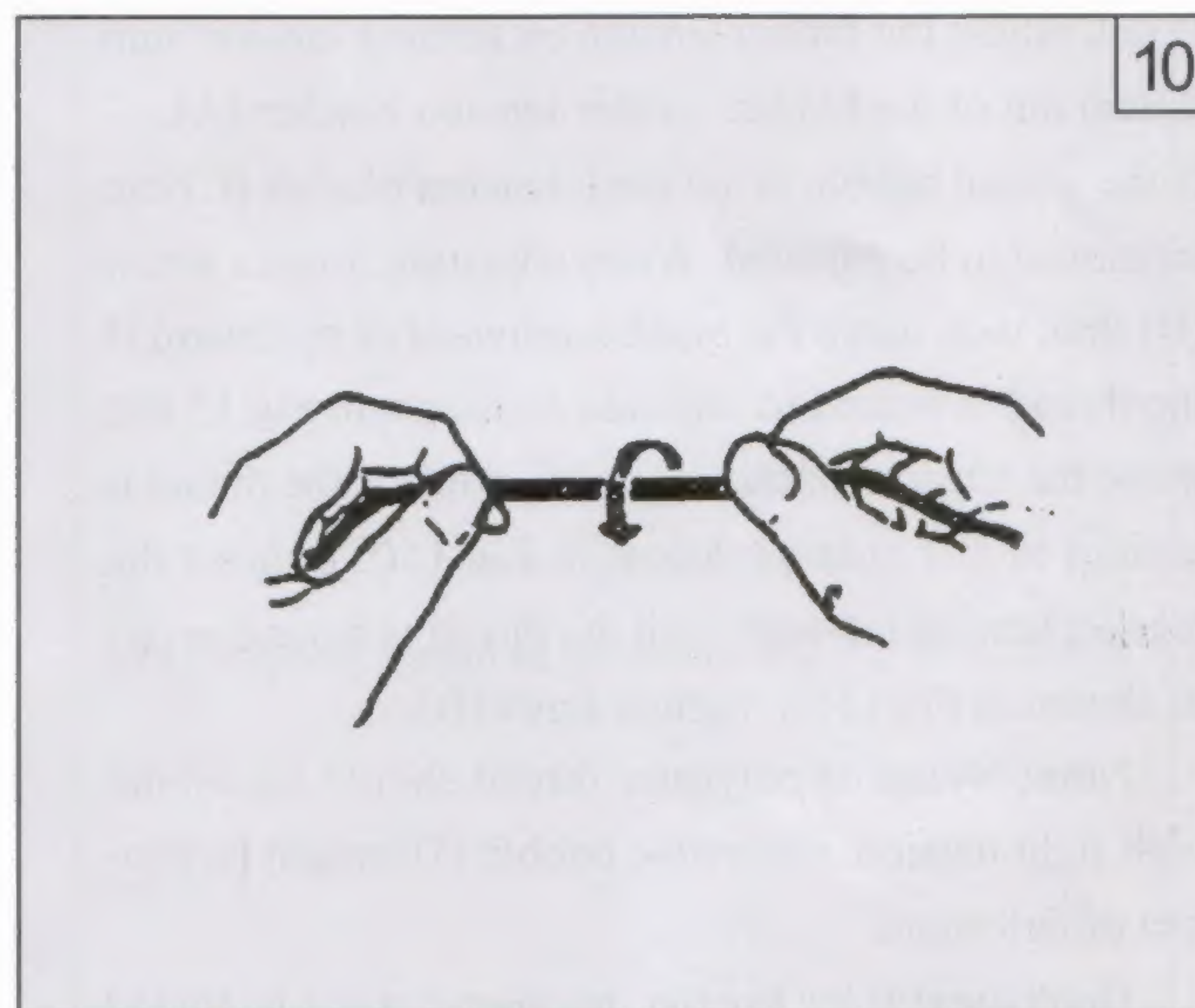
Fig.12(c) Wrong direction of groove.



12. Coordination among the needle the thread and the material (Fig 10)

The needle thread is left-twisted, the bobbin thread is left or right-twisted. Holding the thread, twist it with right hand in the direction of arrow shown in Fig 10, if it is tight, it is left-twisted, contrarily, it is right-twisted.

The needle is DPx17 20#~24# (JK-6320CX DPx17 25#), the needle number must be fitted for the materials. Sewing too heavy the weight of materials, the needle would be breaking and skipping stitch and thread breaking for its too thin, if the needle is too thick, it would damage the clothes for its large needle hole. There for, the selection of needle and thread must be fitted to the materials.

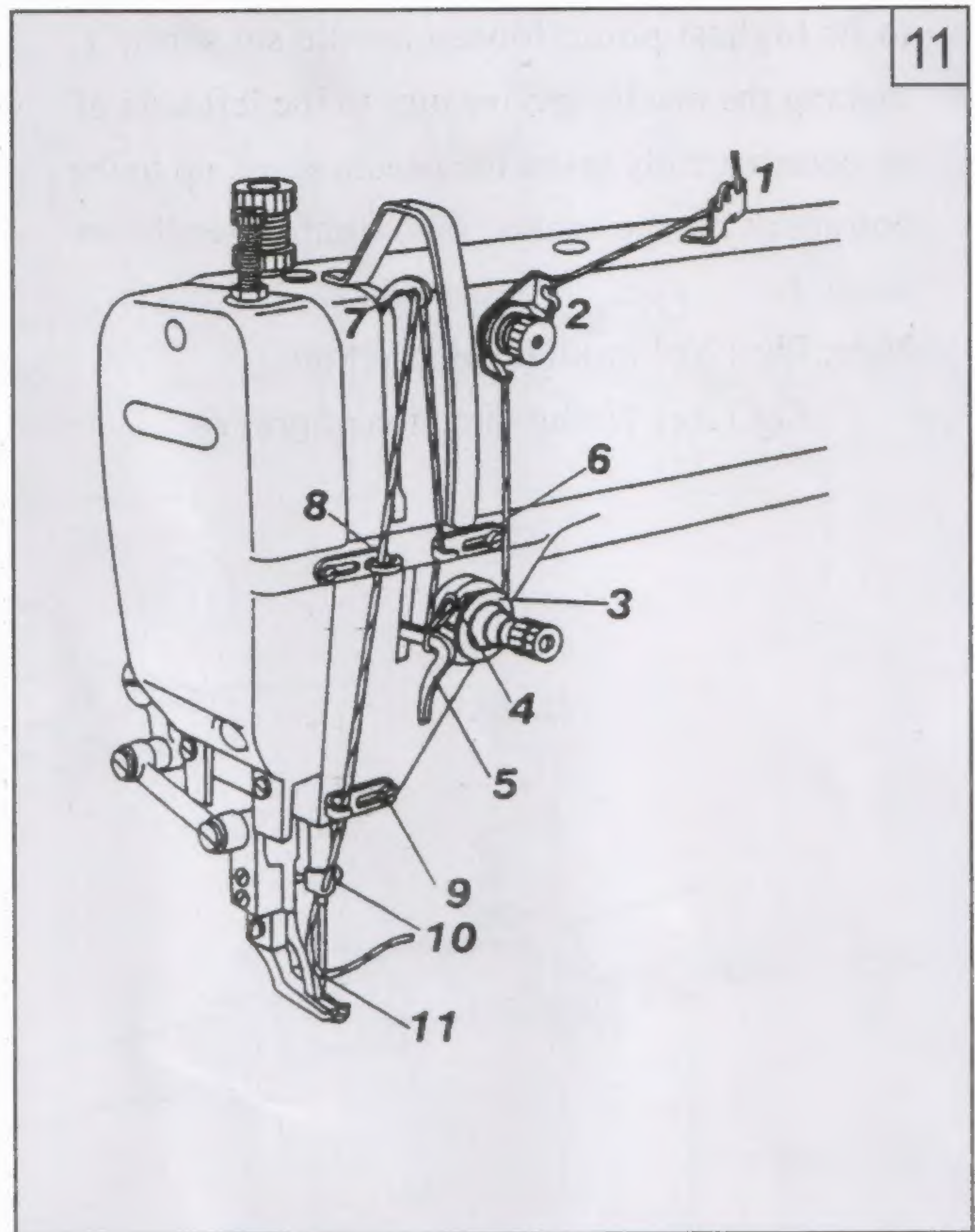


13. Threading the needle thread (Fig 11)

When threading the needle thread, raise the needle bar to its highest position, lead the thread from the spool and pass it in the order instructed.

- (1) Lead the thread down through the three-eye thread guide ① on the top.
- (2) Pass down thru the left hole of thread retainer ②, then down thru the lower hole of thread retainer ②.
- (3) Pass down thru between the two tension disc ③.
- (4) Pass up thru the hook of thread take-up spring ④, thru thread regulator ⑤, thru thread guide ⑥ and up thru the hole of thread take-up lever ⑦.
- (5) Down thru thread guide ⑧, ⑨, and needle bar thread guide ⑩, then pass the thread from the left thru the eye of needle ⑪, draw out the thread approx 100mm from the needle eye.

When drawing the bobbin thread, hold the tip of the needle thread by hand, turn the balance wheel to lower the needle bar and then to lift it to its highest position. Pull the needle thread and then the bobbin thread is drawn up. put the tips of the needle and bobbin thread toward front under the presser foot.



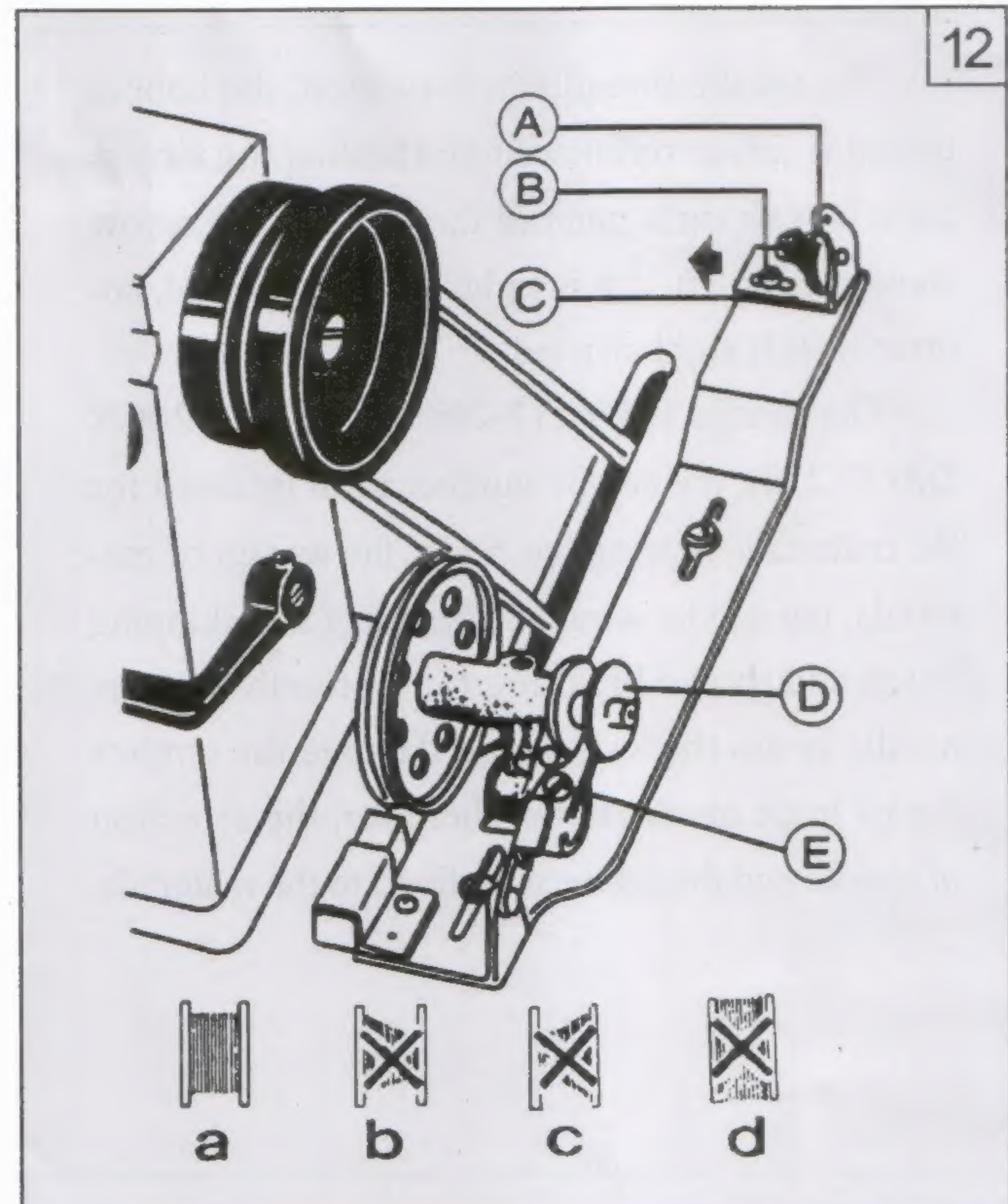
14. Winding adjustment (Fig 12)

The wound bobbin thread should be neat and tight. If not, adjust the thread tension by turning tension stud thumb nut of the bobbin winder tension bracket (A).

If the wound bobbin is not neat, tension bracket (C) can be moved to be adjusted. When adjusting, loosen screw (B) first, then move the bracket leftward or rightward if the thread is wound to one side as shown in Fig.15 (6), move the tension bracket rightward, while if the thread is wound to one side as shown in Fig.15(C), move the tension bracket leftward until the thread is wound neatly as shown in Fig.15(a), tighten screw(B).

Note: Nylon or polyester thread should be wound with light tension. otherwise bobbin (D) might be broken or deformed.

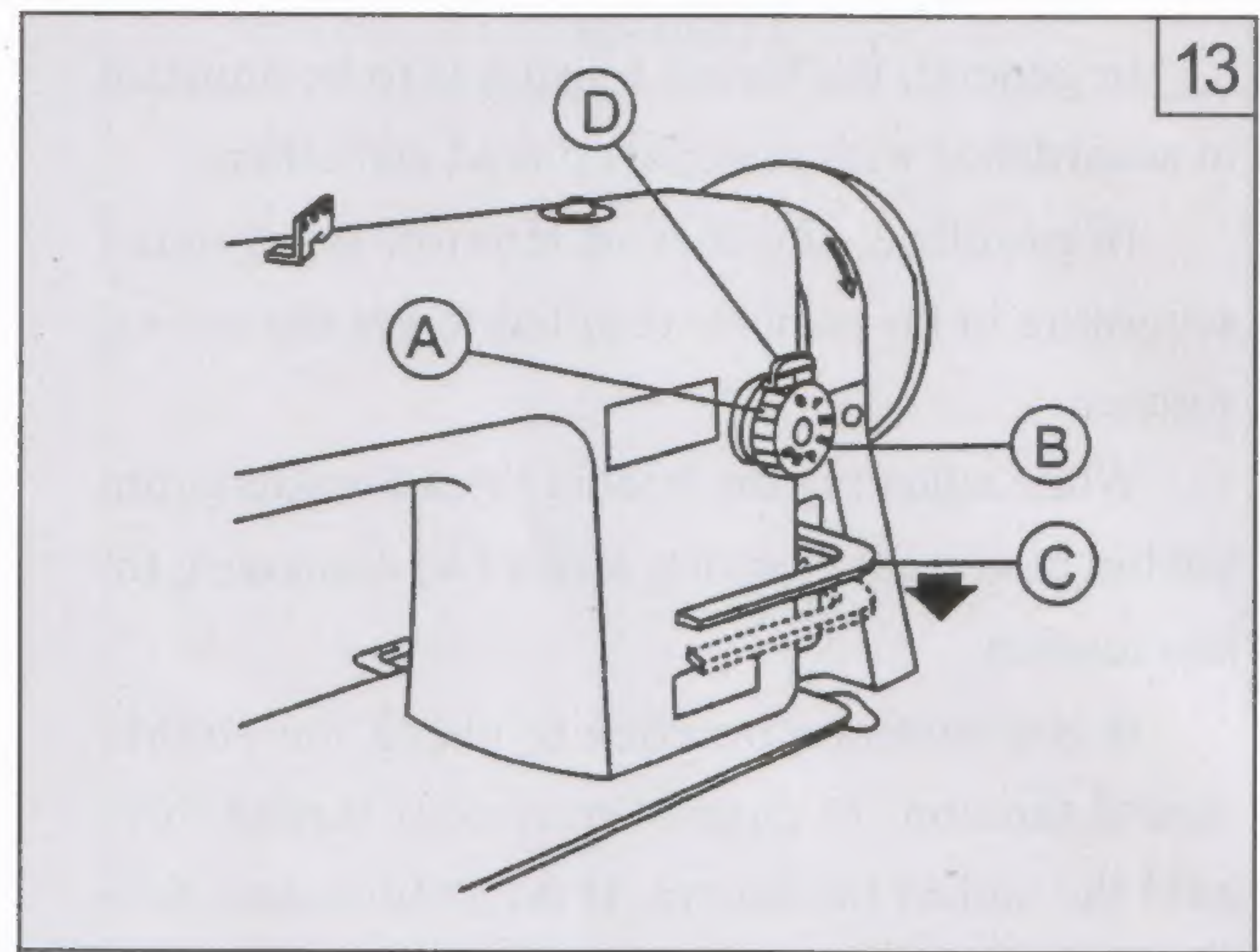
Don't overfill the bobbin, because it make its thread loosening down from the bobbin. The optimum capacity of thread will fill about 80% of bobbin outside diameter, and this can be adjusted by stop latch screw (E).



15. Setting the stitch length and controlling the reverse sewing (Fig 13)

Stitch length can be set by turning stitch length regulating dial (A). The figures on the stitch length regulation dial plate (B) indicate the stitch length.

Reverse sewing can be obtained when feed reverse lever (C) is depressed and forward sewing can be restored automatically when feed reverse lever (C) is released.



16. Thread take-up oiling (Fig 14)

Thread take-up section adopts woolen thread oiling. after long time of use, its function lost, so replace with a new one.

① Open the face plate, remove the pressure screw, lock nut and presser bar.

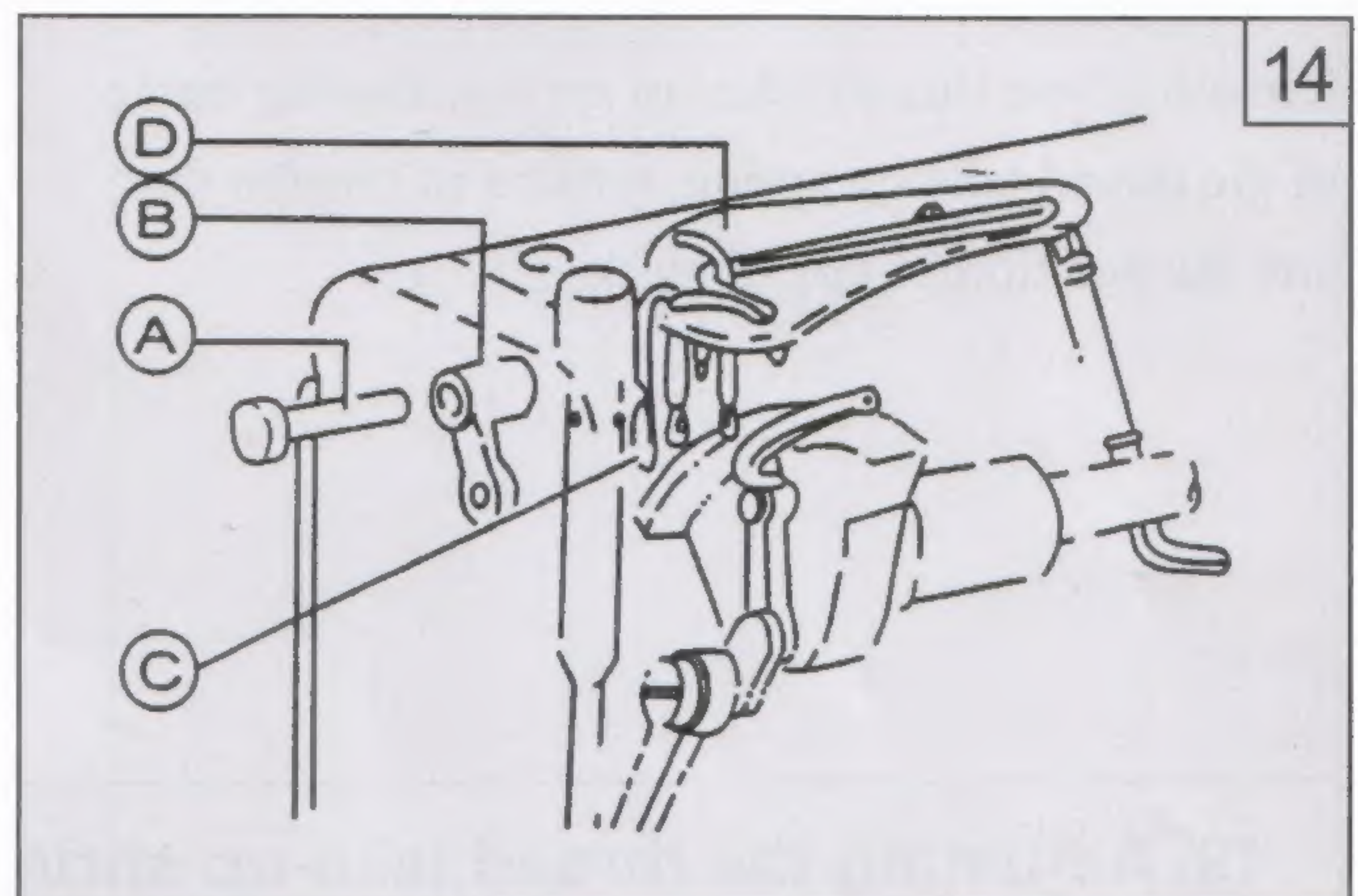
② Remove Hinge (A) and Lever (B)

③ Draw out Oil wick (C).

④ Loosen the wick fix screw on the arm top, and take out Set Plate (D).

⑤ Replace with a new one.

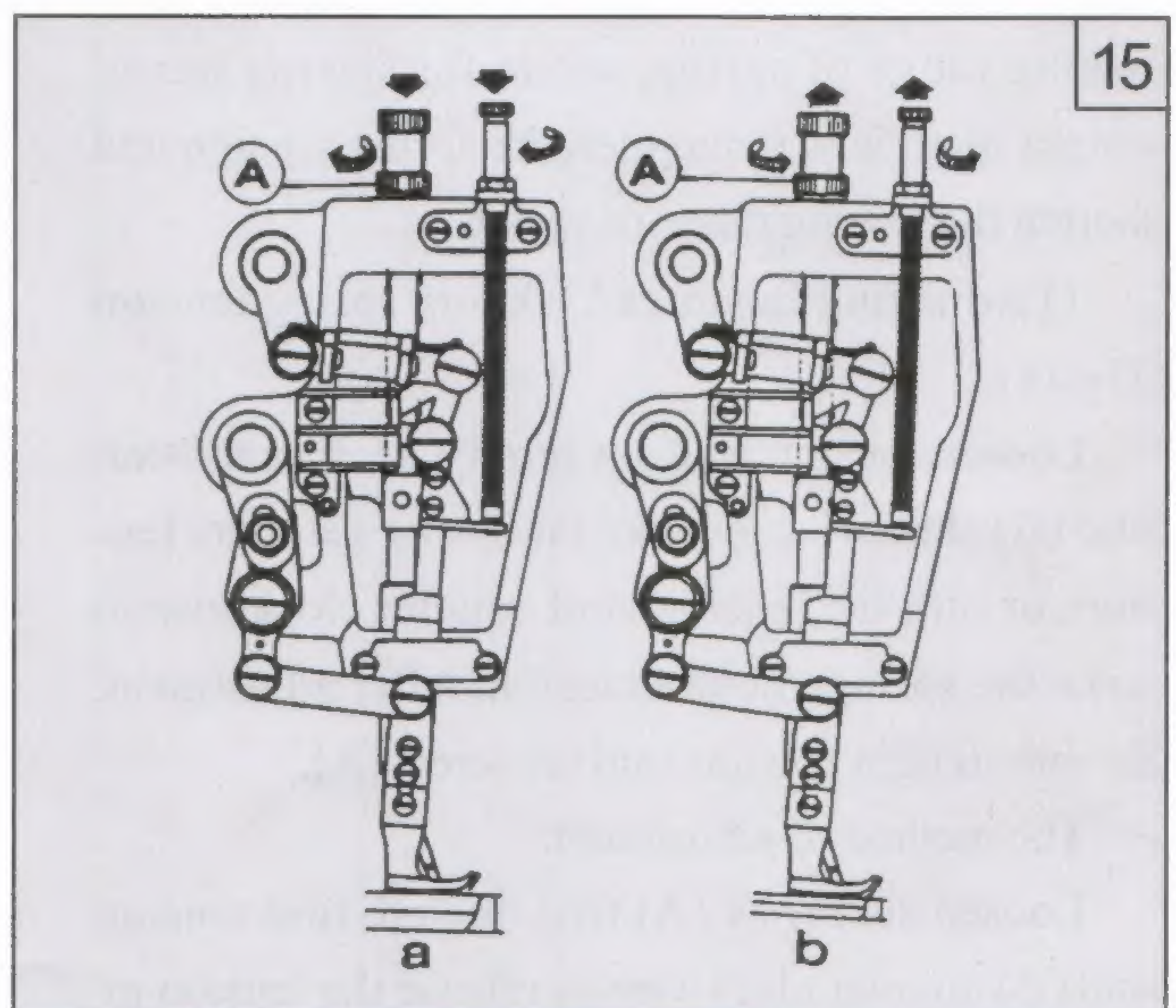
⑥ Installing is a reverse sequence.



17. Adjusting the pressure of presser foot (Fig 15)

Pressure on presser foot is to be adjusted in accordance with materials to be sewn. Loosen lock nut (A). If heavy materials to be sewn, turn pressure regulating thumb screw clockwise as shown Fig.20 (a) to increase the pressure. While light materials to be sewn, turn the pressure regulating thumb screw counter clockwise as shown in Fig. 20 (b) to decrease the pressure on presser foot, then tighten lock nut (A).

The pressure of presser foot is proper as the sewing materials can be fed normally.



18. Adjusting the thread tension (Fig 16 17)

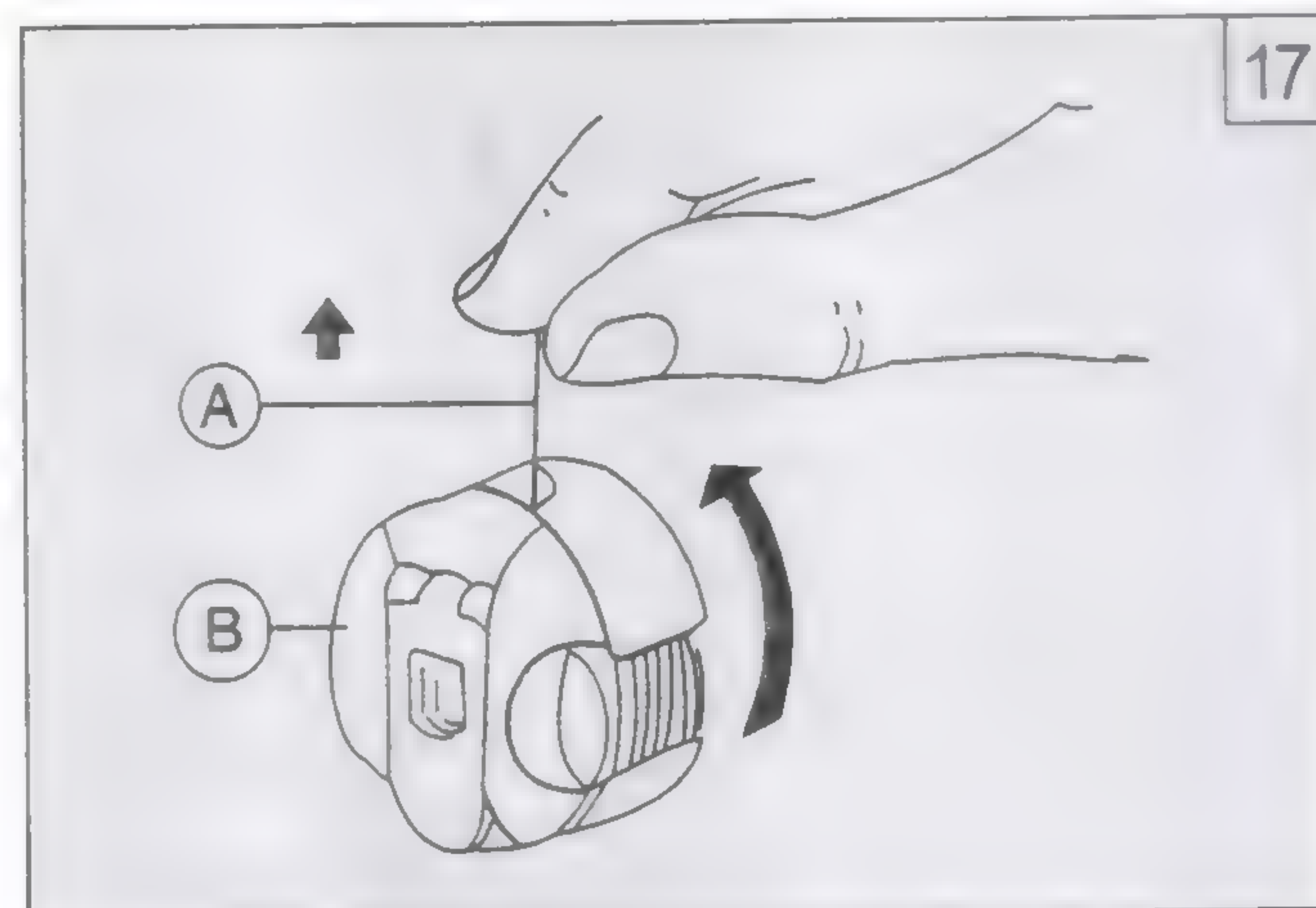
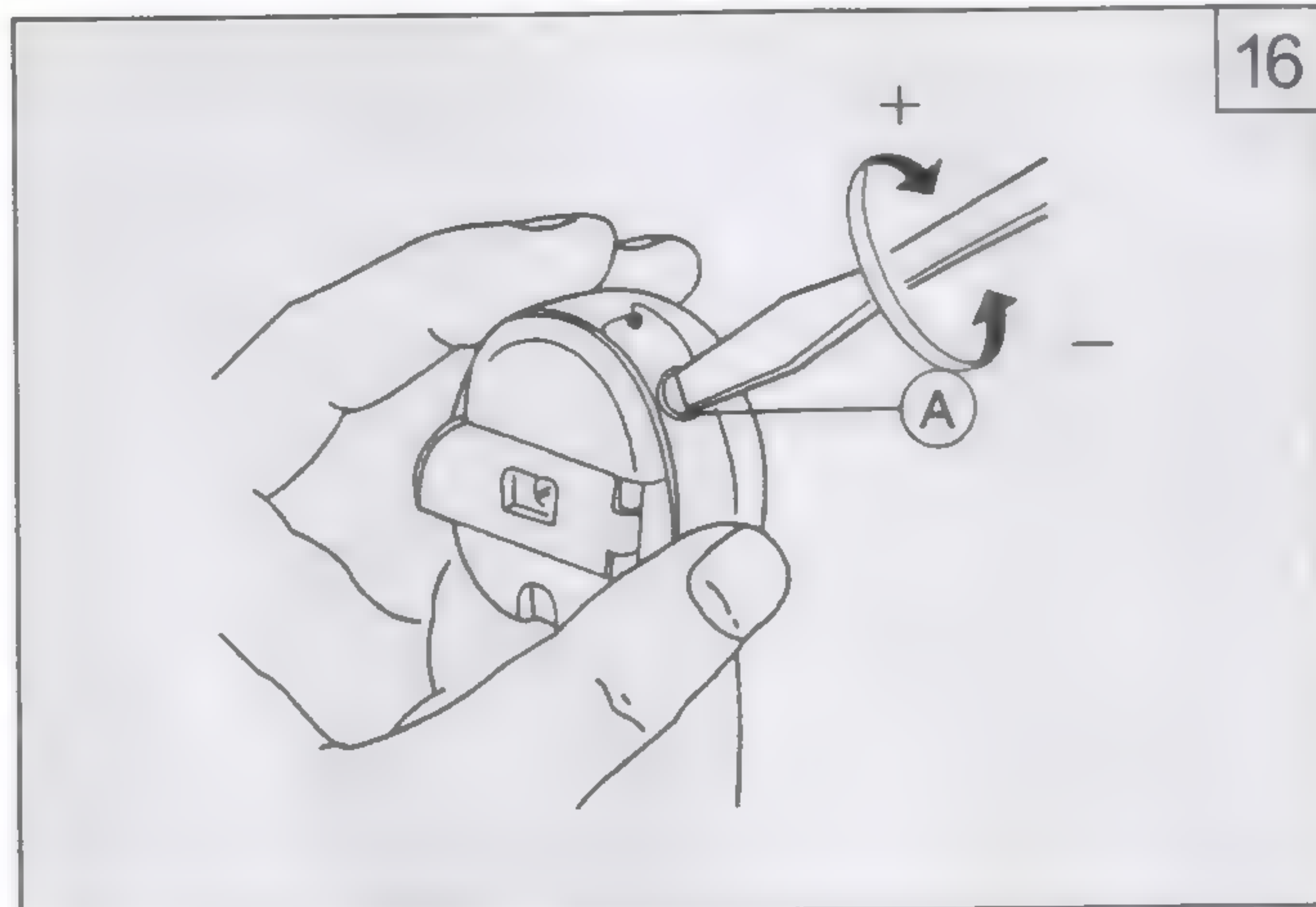
In general, the thread tension is to be adjusted in accordance with materials thread and others.

In practice, the thread tension is adjusted according to the stitches resulted to get the normal stitches.

When adjusting the bobbin thread tension, turn bobbin case tension spring screw (A) clockwise for less tension.

It is a common practice to check the bobbin thread tension. In case of polyester thread 50=, hold the end of the thread. If the bobbin case falls down slowly, the proper tension is obtained.

The needle thread tension should be adjusted with reference to the bobbin thread tension. The needle thread tension can be adjusted by changing tension of the thread take-up spring, sewing range of the thread take-up spring, tension of tension disc, and the position of thread guide.



19. Adjusting the thread take-up spring (Fig18 19)

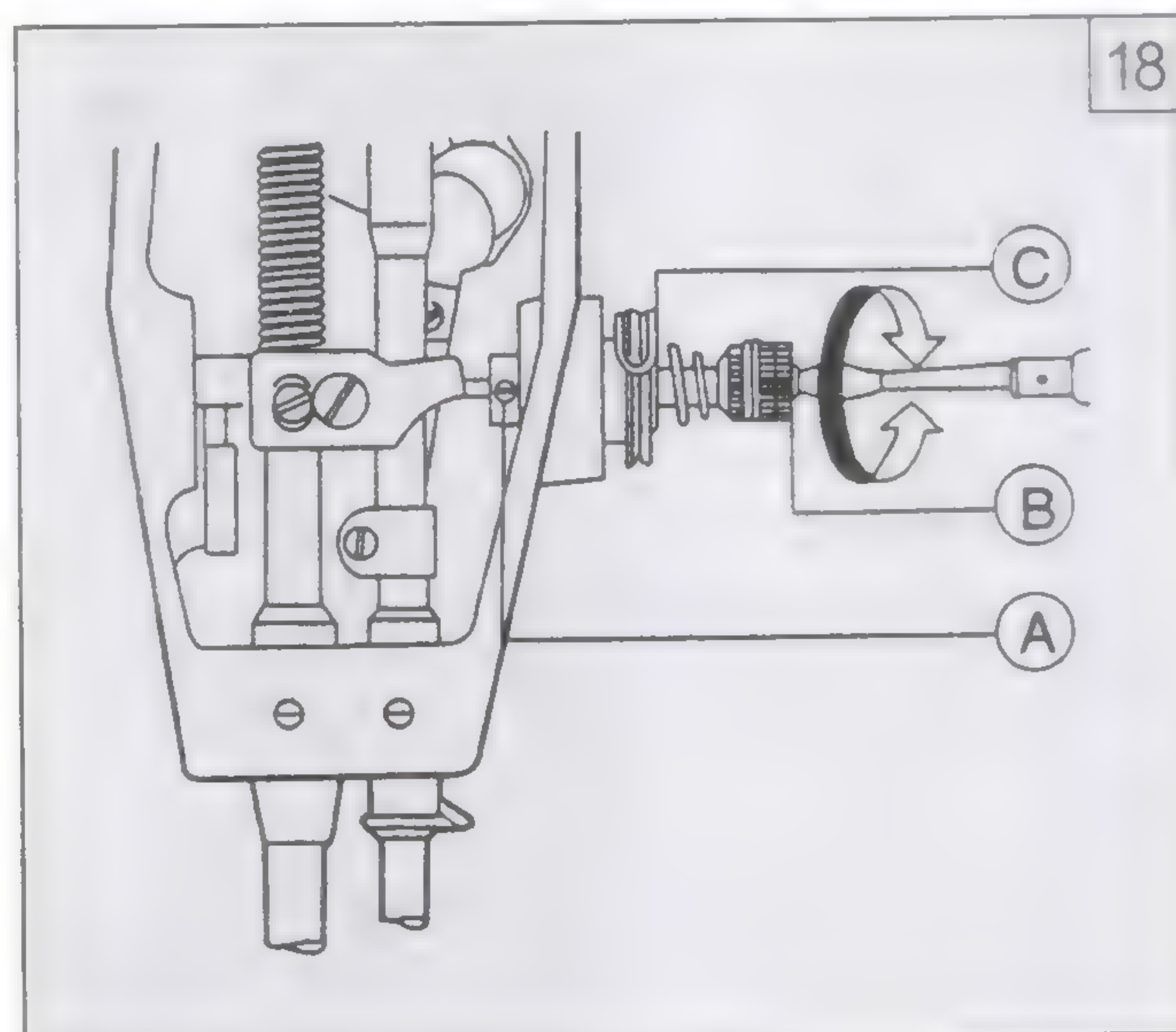
The normal sewing range of thread take-up spring is 5-8mm. For sewing light weight materials (short stitch), weaken the spring tension and widen the sewing range of spring, while for sewing heavy weight materials, strengthen the spring tension and shorten the sewing range of spring.

1) Adjusting the thread take-up spring tension (Fig.18).

Loosen tension stud set screw (A), turn tension stud (B) clockwise to make the spring get more tension, or turn the tension stud counter clockwise to make the spring get less tension, After adjustment, Be sure to tight tension stud set screw (A).

The method of adjustment:

Loosen set screw (A) first, then to turn tension stud (B) counter clockwise to release the tension of

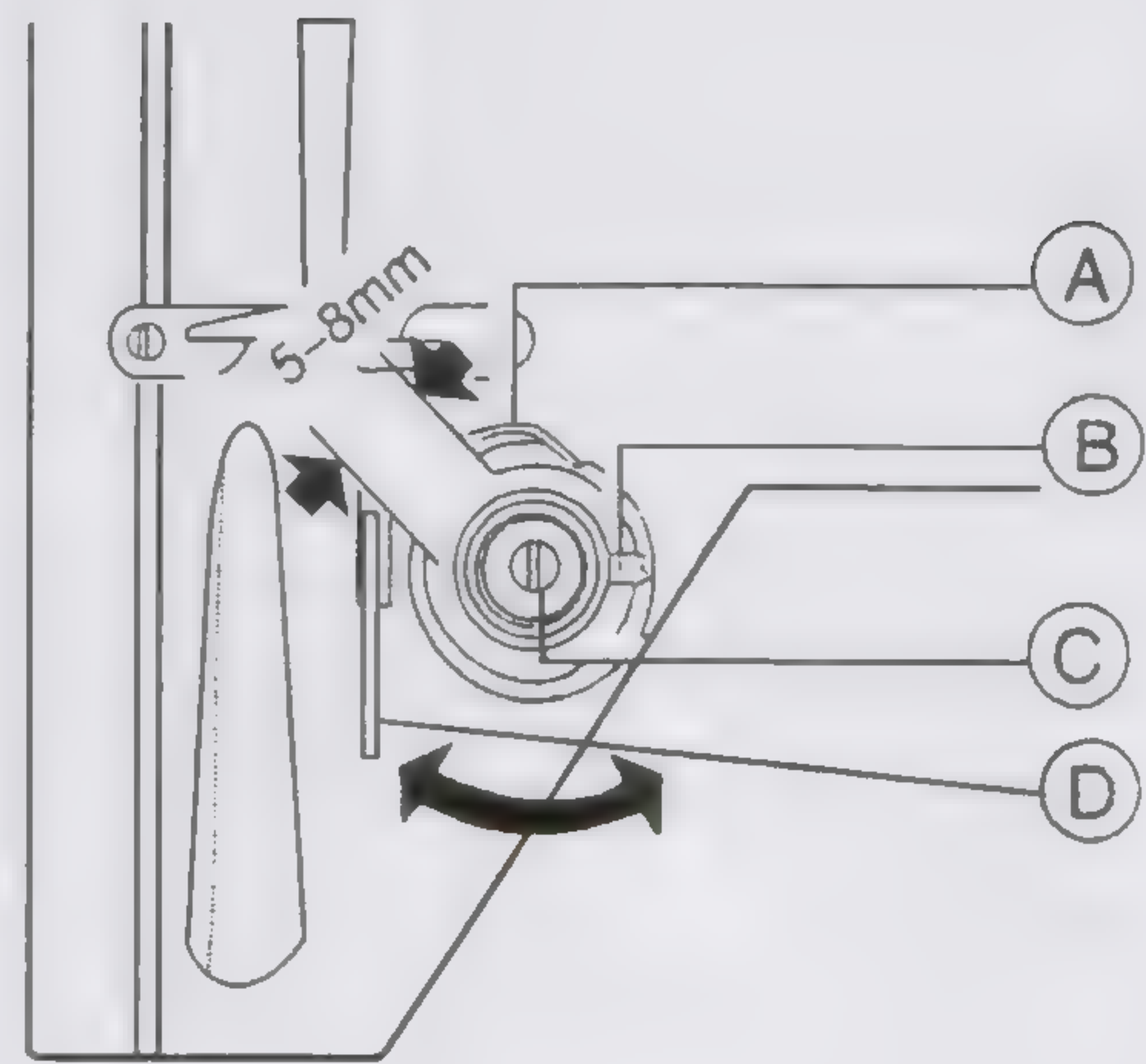


thread take-up spring (C) to zero, and to turn tension stud (B) clockwise until spring (C) just comes into contact with the stop slot on the thread take-up spring regulator, then to further turn tension stud (B) counter-clockwise by 1/2 turn After adjustment, tighten tension stud set screw (A).

2) Adjusting the sewing range of thread take-up spring (Fig 19)

Loosen set screw (B), turn tension complete (C) clockwise to increase the sewing range or turn tension complete (C) counter clockwise to decrease the sewing range.

Before delivery, the thread take-up spring is properly adjusted, Readjustment is needle only in the case of sewing special materials or with special thread.



20. Adjusting the tension of needle thread & bobbin thread (Fig 20 21 22)

The position of the thread guide affects sewing quality, so it must be adjusted according to the materials to be sewn.

Thread guide position	Leftward	Center	Rightward
Material	Heavy	Medium	Light

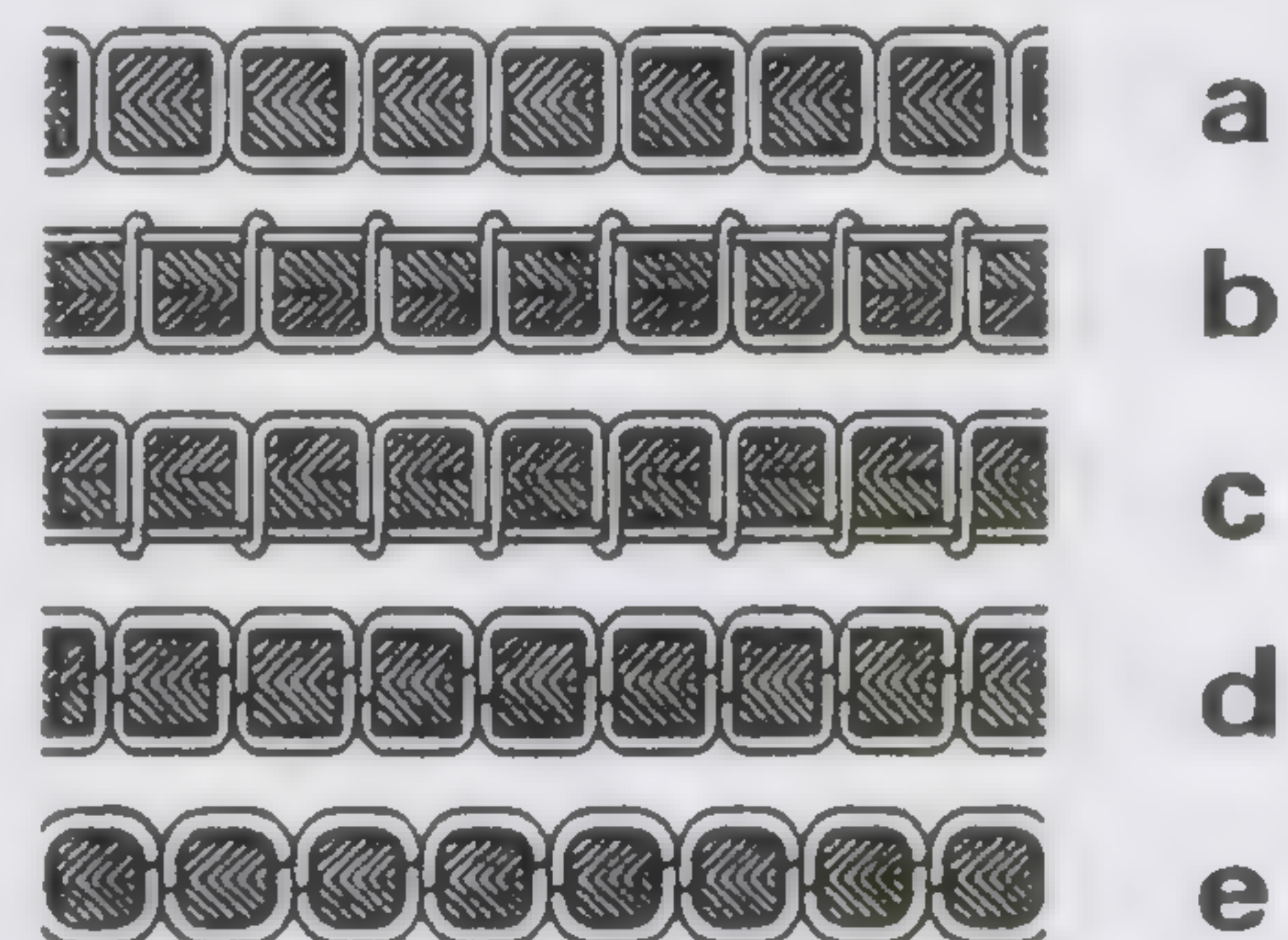
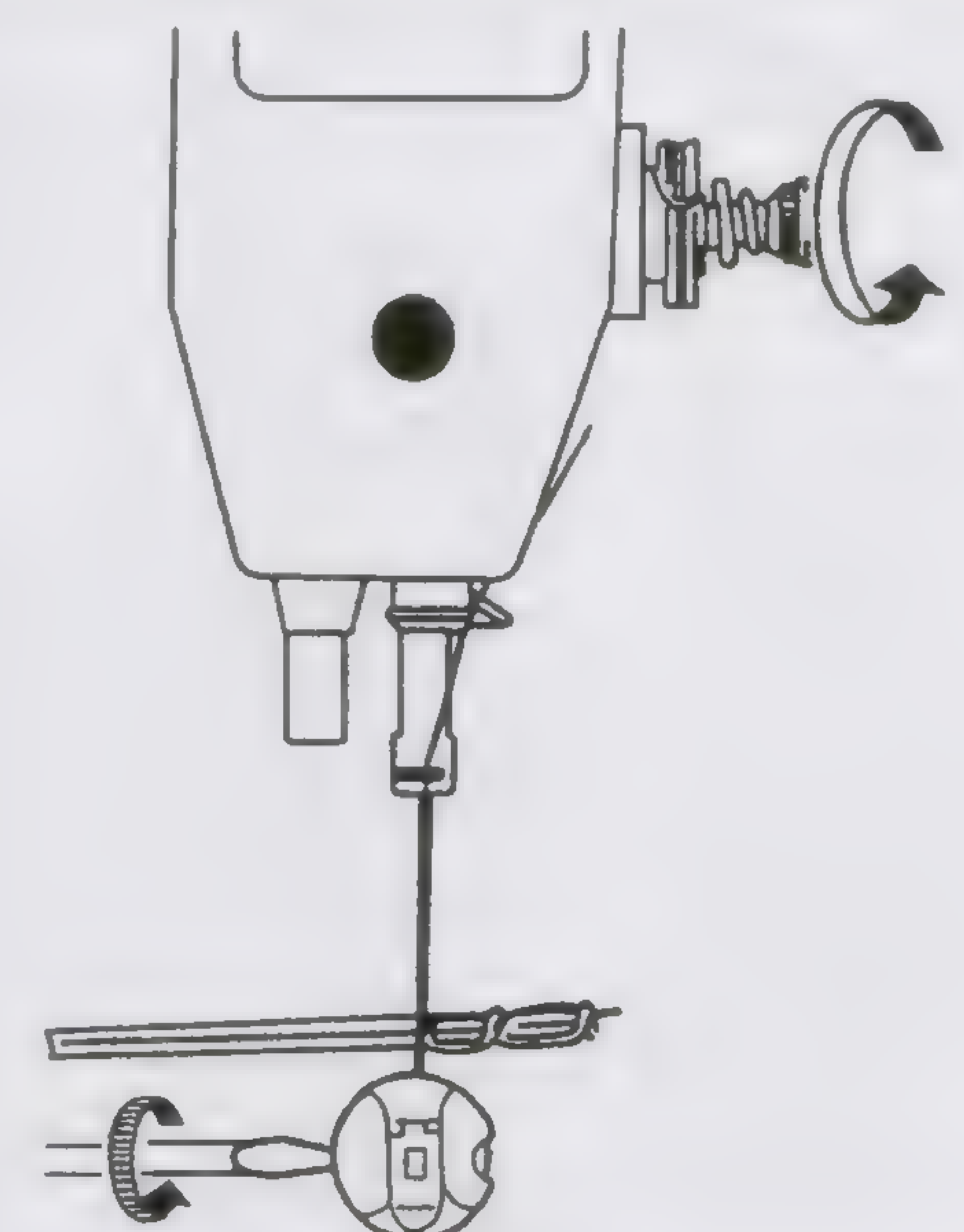


Fig.20 shows the various type of stitch forms.

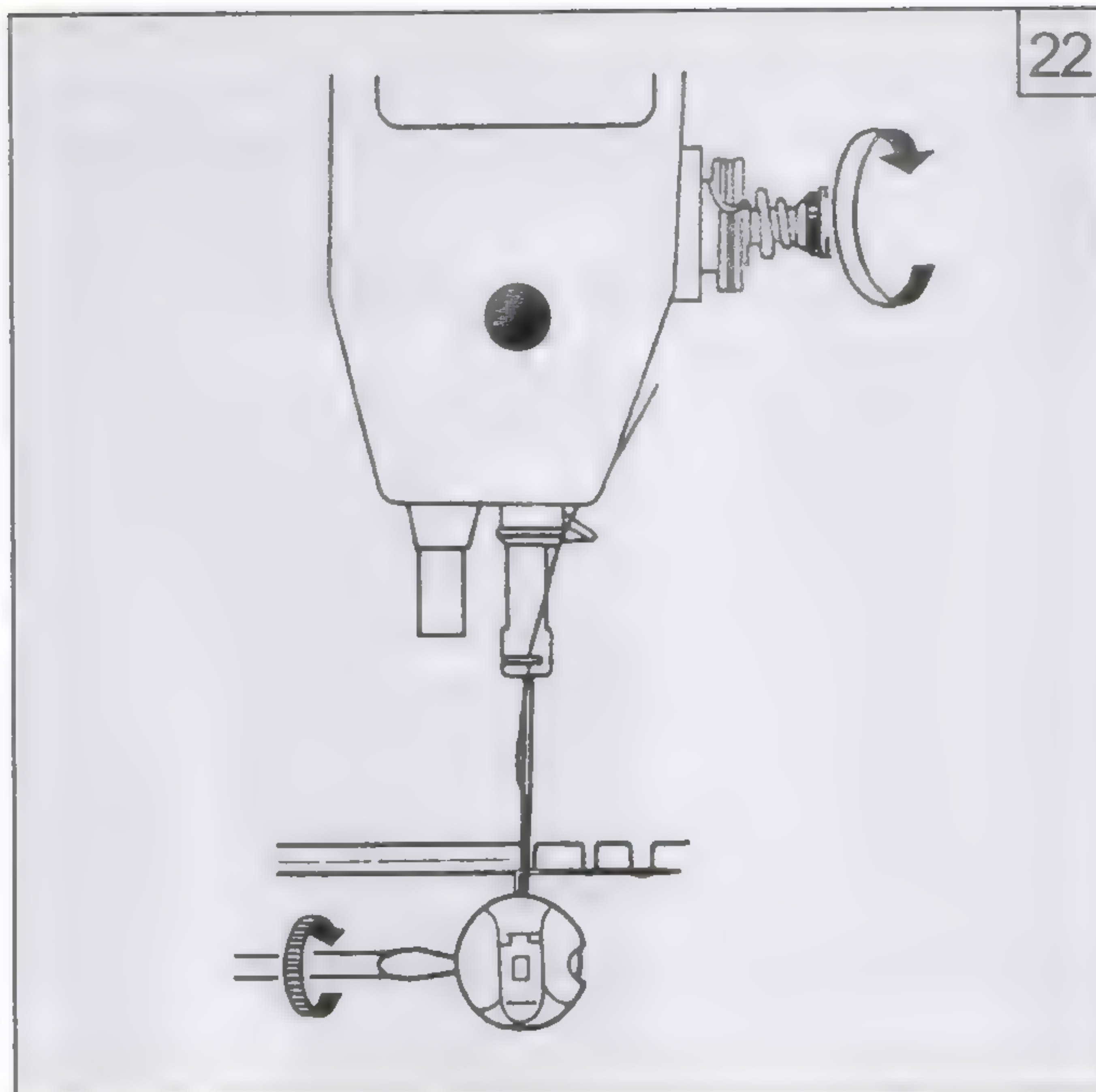
Normal stitch form should be as shown is Fig.20 (a). When abnormal stitches occur with pucker ring or thread breakage, the tension of needle thread and bobbin thread must be adjusted accordingly.

(a) The needle thread tension is too strong or the bobbin thread tension is too weak, turn the tension regulating thumb nut counter clockwise to make the needle thread get less tension or tighten the bobbin case tension reuglating screw with small plastic screw driver to make the bobbin thread get more tension (Fig.21).



(b) The needle thread tension is too weak or the bobbin thread is too strong, turn the tension regulating thumb nut clockwise to make the needle thread get more tension or turn the bobbin case tension regulating screw counter clockwise with small plastic screw driver to make the bobbin thread get less tension (Fig.22)

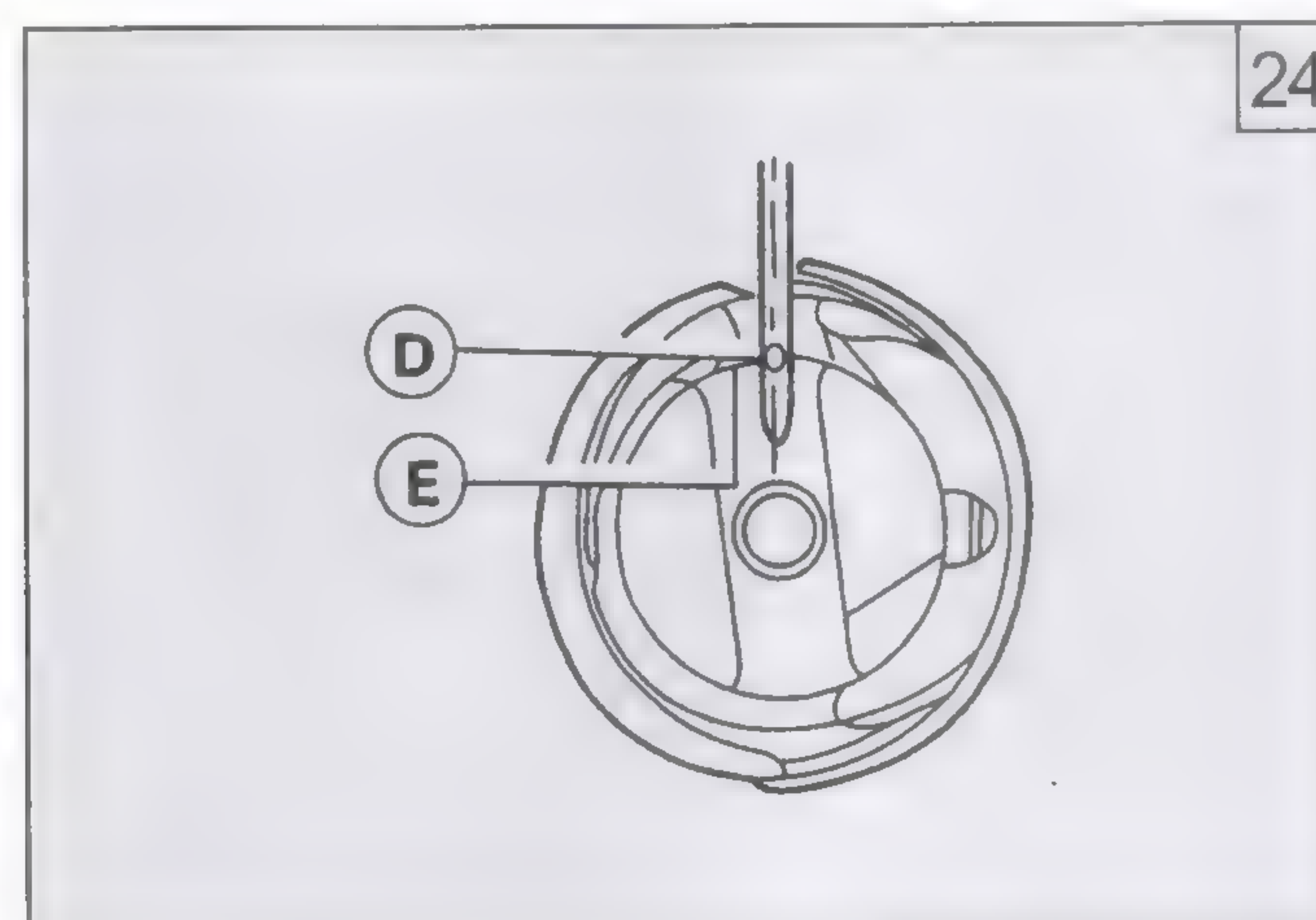
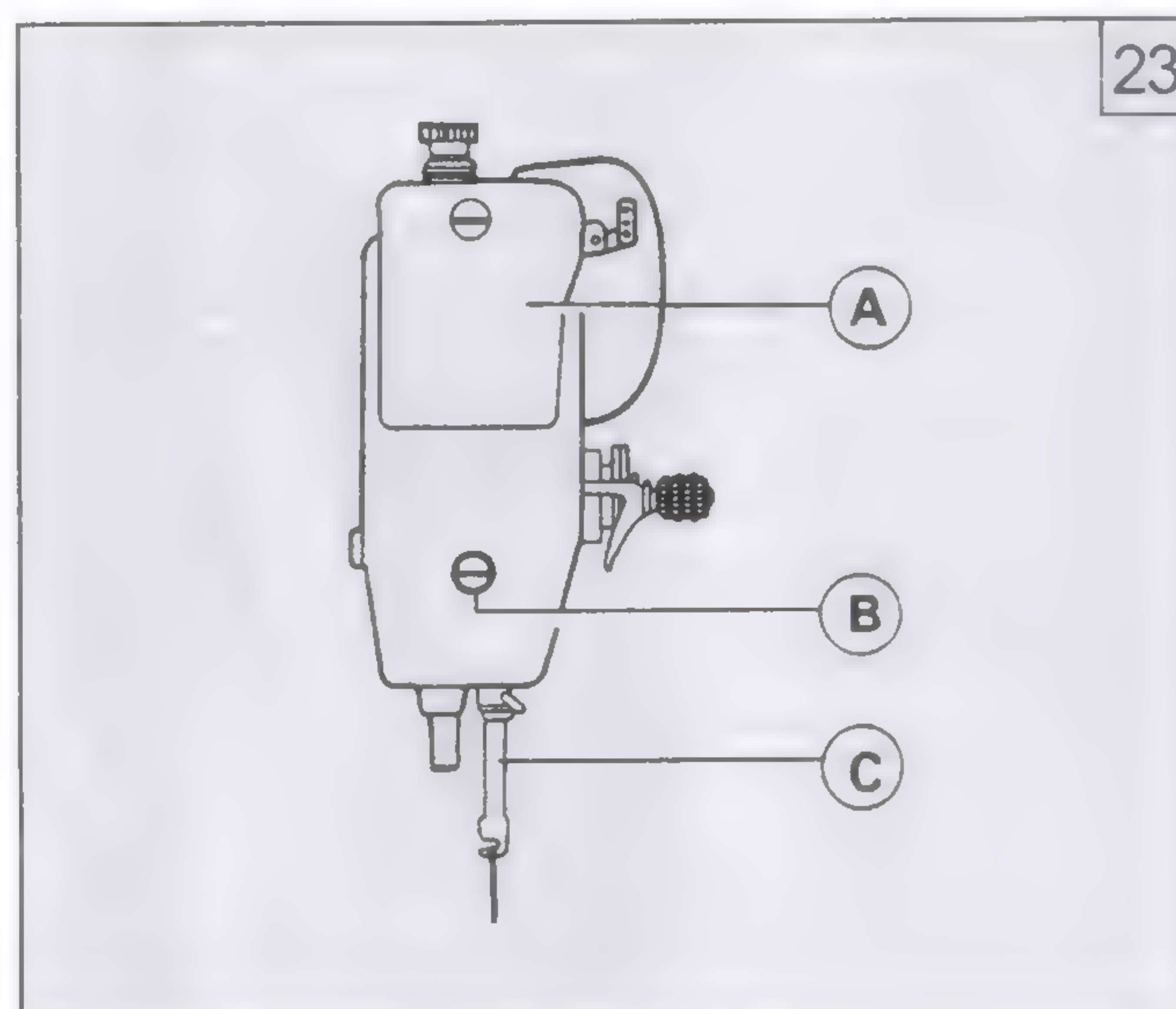
(c) Other abnormal stitches as shown in Fig.20
(d) (e) adjustment can be made which referece to the above methods.



21. Timing between the needle and the rotating hook (Fig23 24 25 26)

1. Adjusting the position of needle bar

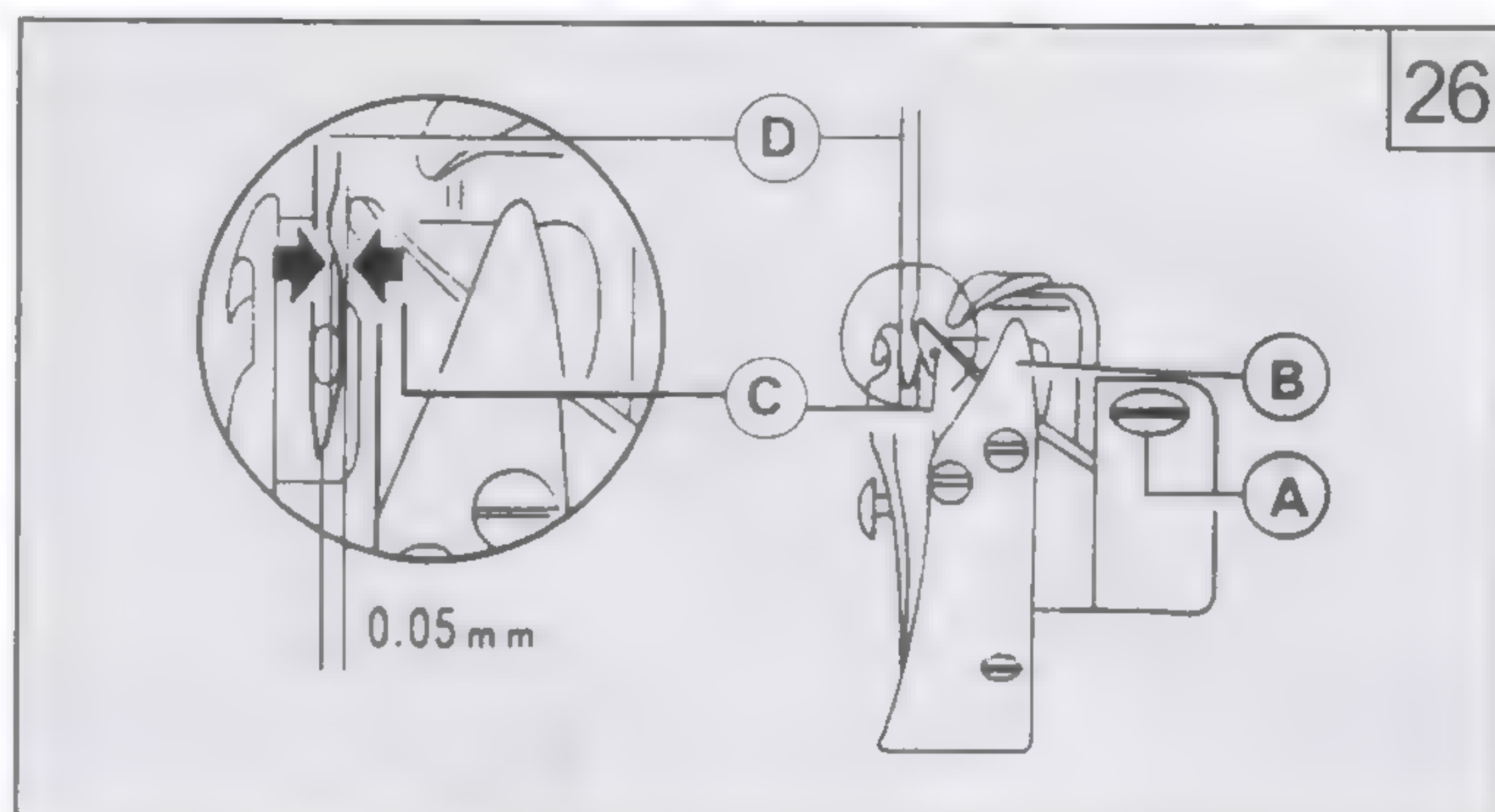
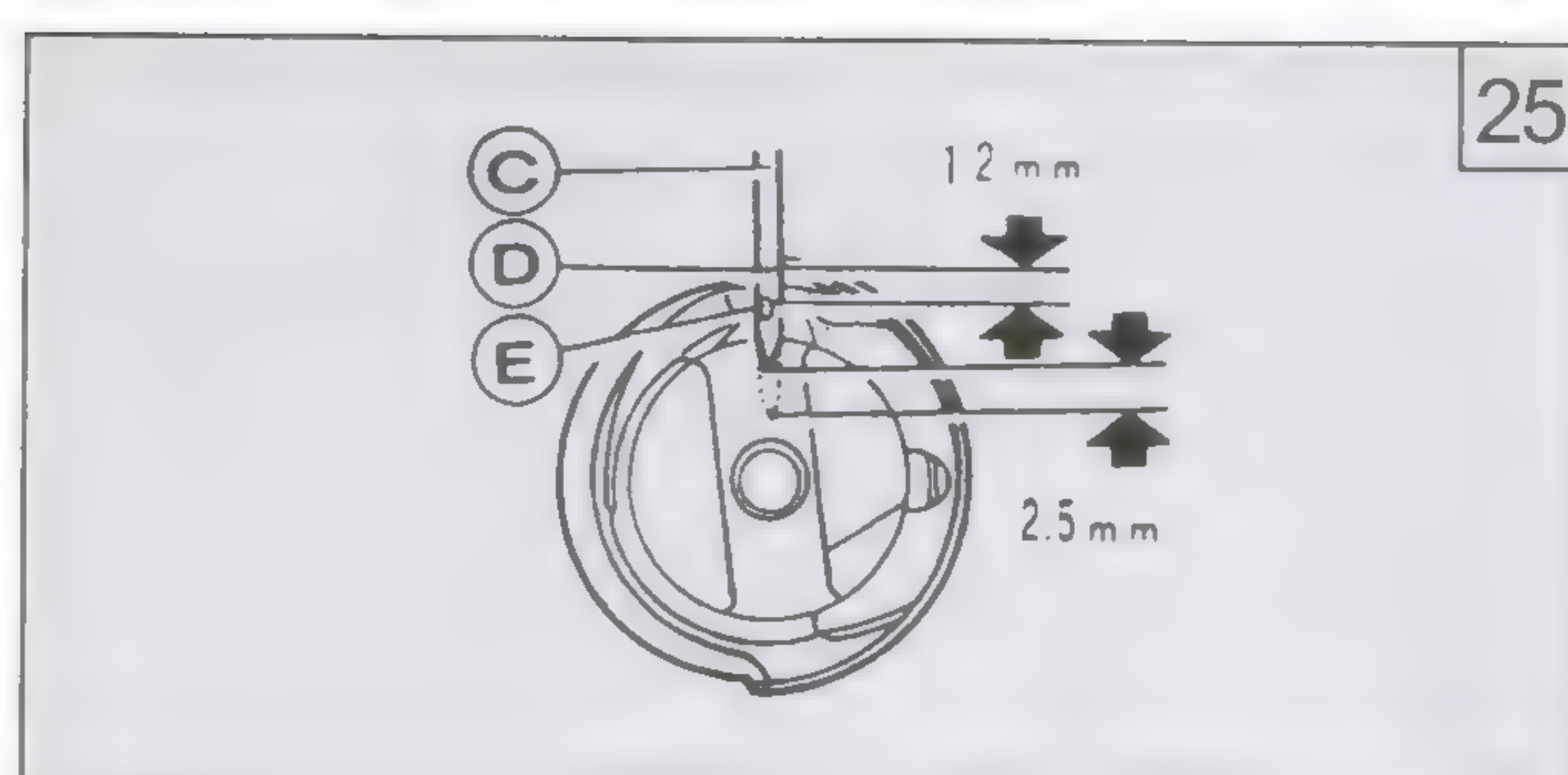
Turn the balance wheel to locate the needle bar (C) at its lowest position, remove the rubber plug in the face plate (A), then loosen the needle bar (C) connecting stud clamping screw (B) and move the needle bar (C) vertically to locate the timing position (The timing position of the needle bar is: when the needle bar at its lowest position, the center of needle eye (D) coincide with inside surface (E) of bobbin case holder as shown in Fig.24). Tighten clamping screw (B), plug the rubber plug.



2. Adjusting rotating hook point timing with needle.

The motive relation between rotating rotating and needle affects the sewing quality. Standard timing relation is: turn the balance wheel to locate needle bar to its lowest position, and lift back 2.5mm the rotating hook point (D) should be coincides with needle center line (C), and hook point (D) is 1.2mm above the upper edge (E) of needle eye.

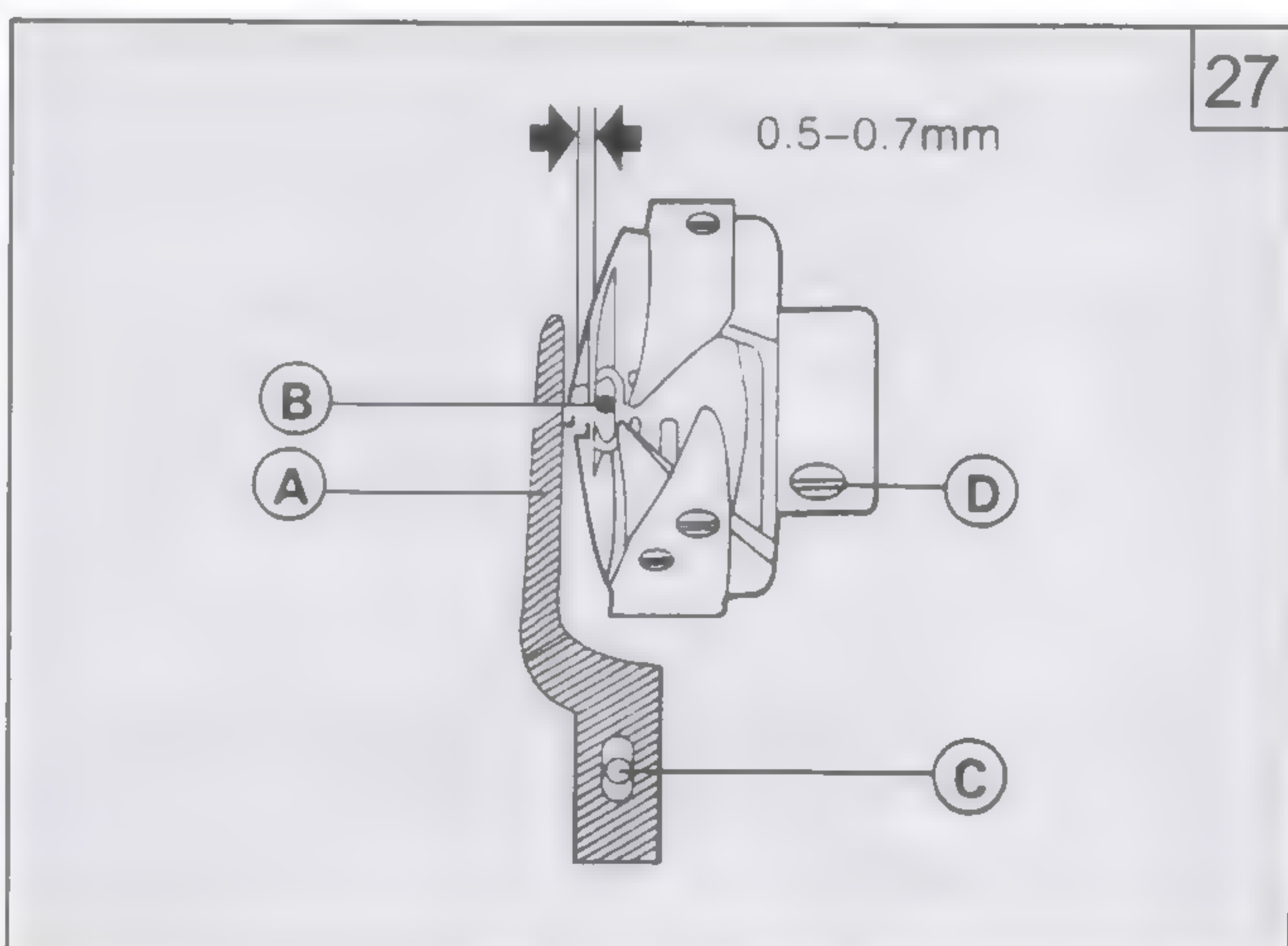
When adjusting the rotating hook point timing also to note the clearance between notch bottom of needle (D) and hook point (C) of approx 0.05mm must be maintained. (Fig 26)



22. Removing and installing the rotataing hook (Fig 27)

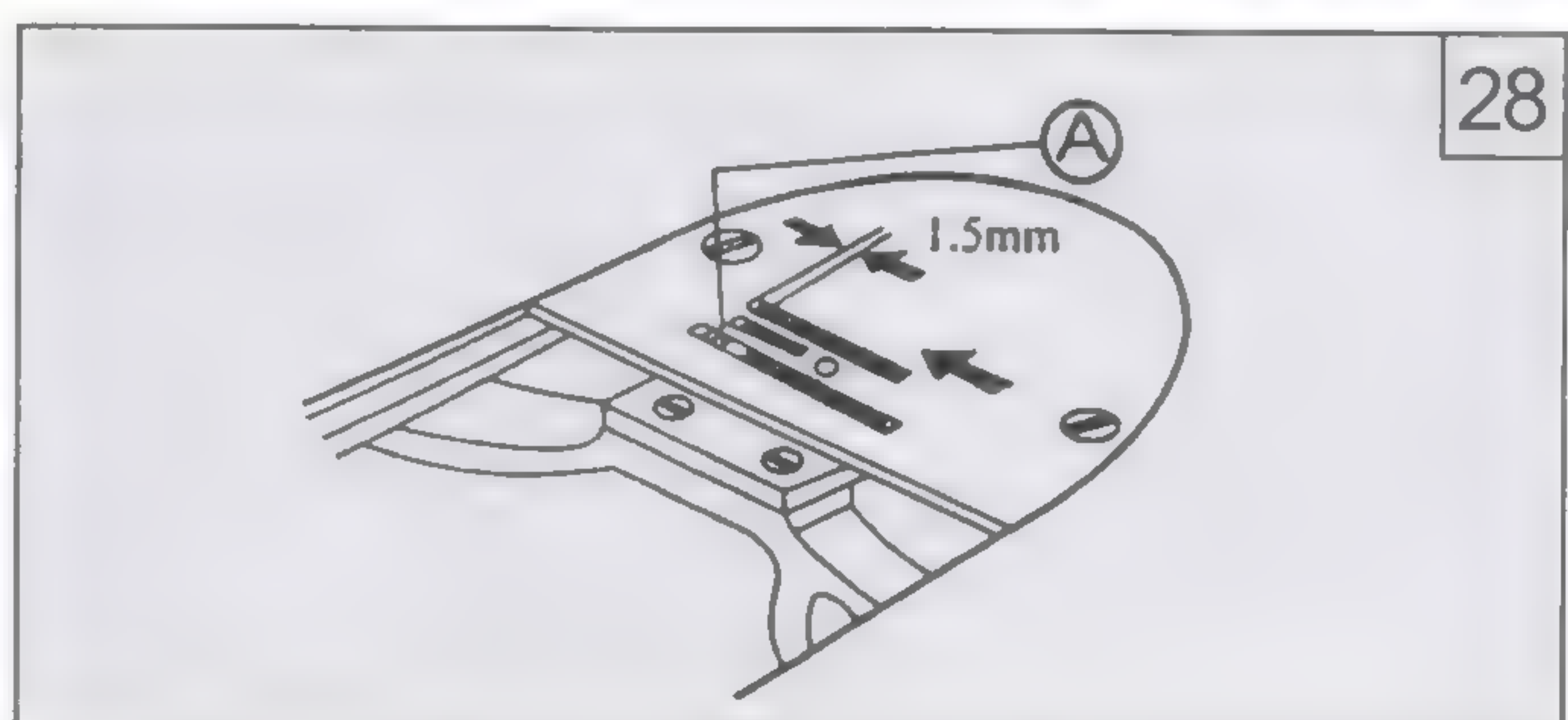
Lift the needle bar to its highest position. remove the throat plate. take down the needle and the bobbin case. loosen rotating hook bobbin case holder position bracket screw (C) and take down position bracket (A). then loosen set screw. (D) of rotating hook to keep hook freely, turning around its axis, turn the balance wheel first to raise the feed bar to its highest position, at this time, take down the rotating hook slowly while turning it to keep away from the feed dog support. Installing the rotating hook can be done in reverse sequence.

The projecting flange of the position bracker (A) should be engaged in the notch (B) of the bobbin case holder, and maintain a clearance of 0.5~0.7mm between projecting flange top and the bottom of notch while installing.

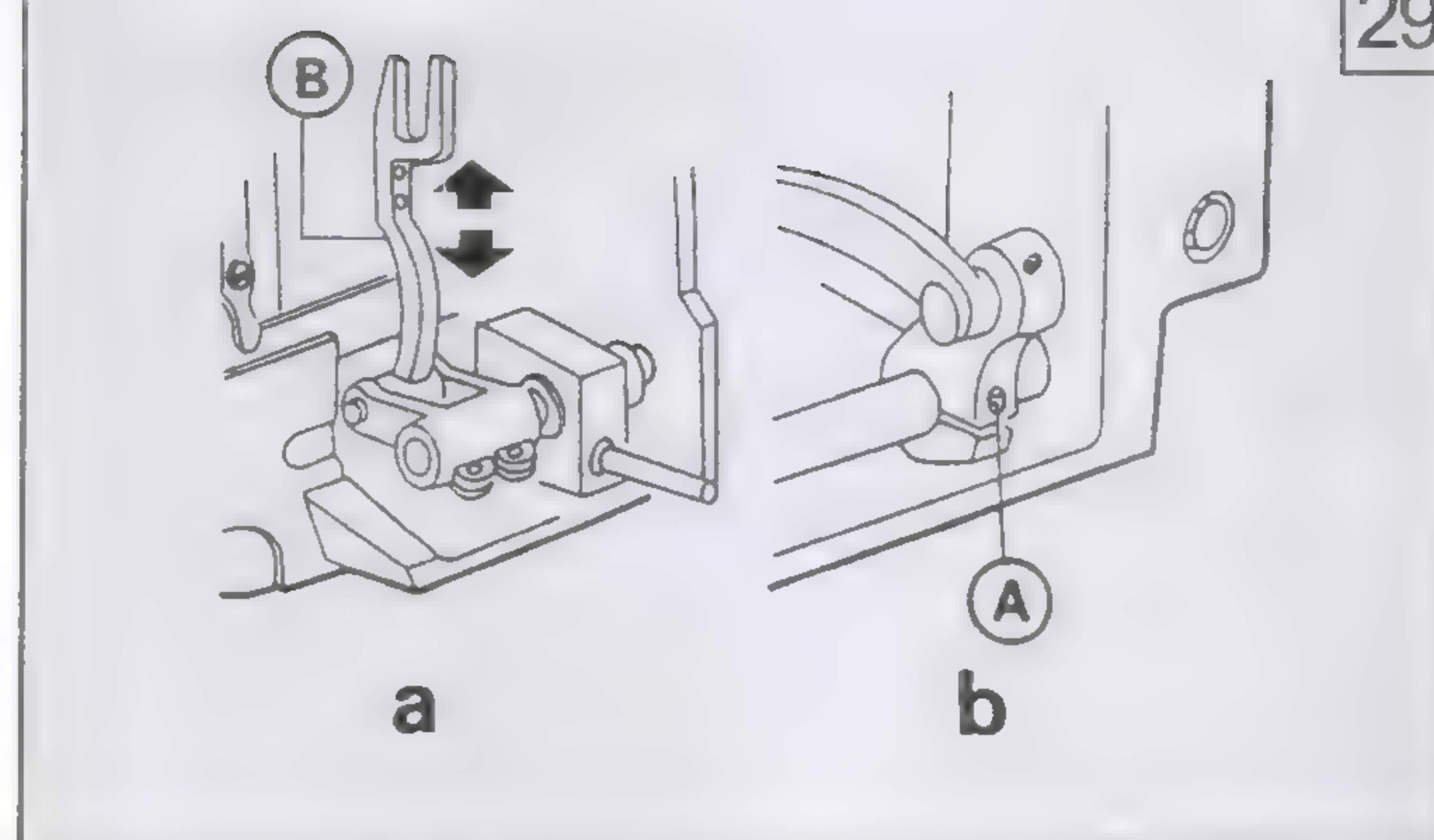


23. Installing feed dog (Fig 28 29)

When feed amoun is at the max. The front end of feed dog (A) is near the front of throat plate slot, the gauge between the two is 1.5mm. This is the standard position of feed dog.



dog to the front end of throat plate, Loosen screw A (See Fig 29b), move feed dog support B in the direction shown by arrow (Fig. 29a) to adjust. After adjustment tighten screw (A).



24. Feed dog horizontal Adjustment (Fig 30)

Feed dog is 0.8~1.2mm above the surface of throat plate horizontally.

When sewing condition requires tilting, adjust like this:

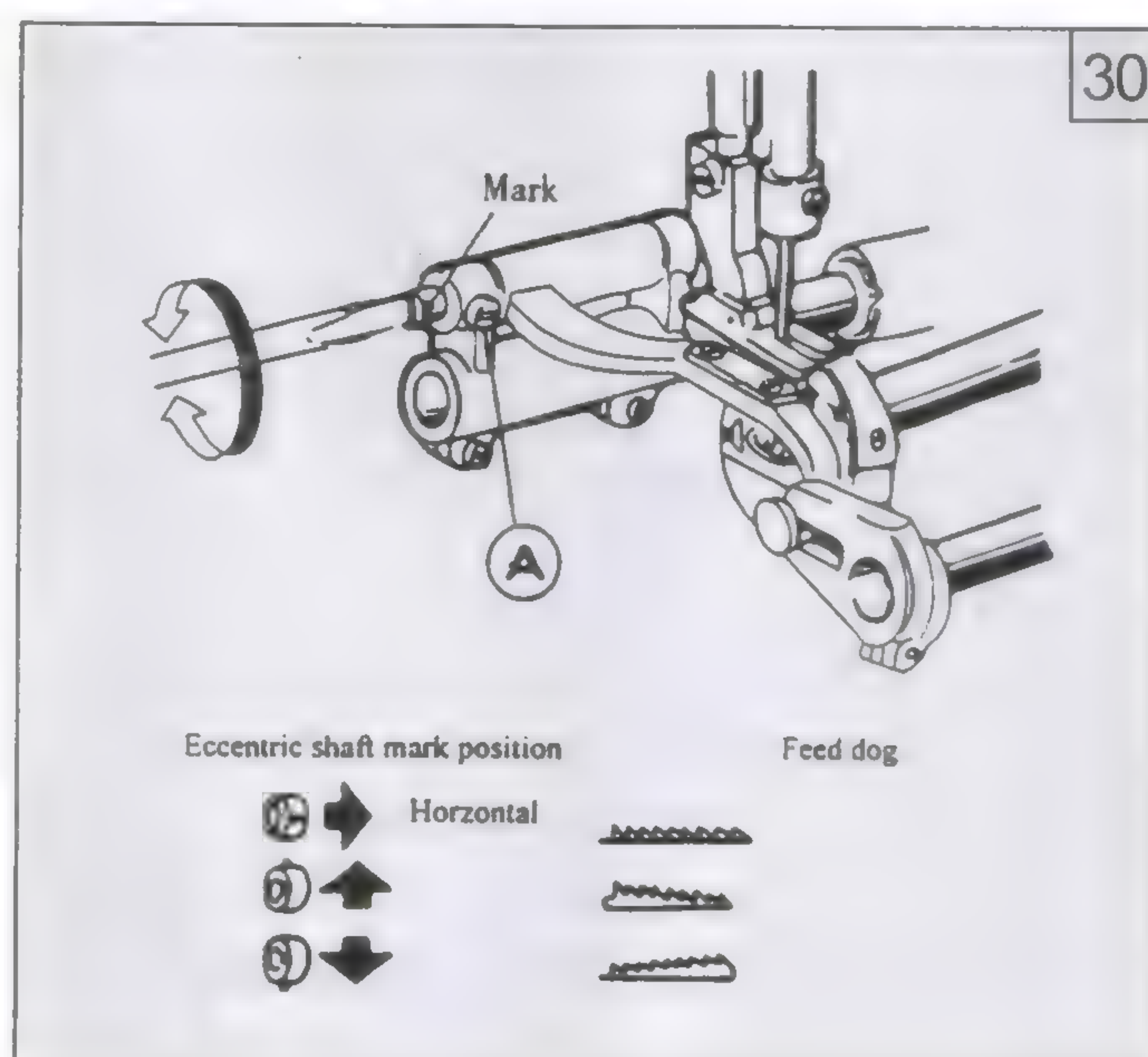
Loosen screw (A).

Press against the slot of eccentric shaft with a screw driver to turn eccentric shaft left and right.

Tighten screw (A).

The front of feed dog is higher, which can prevent perckering and no skiipping.

The front of it is lower, which can prevent maferial sliding and no breakage of bobbin thread.

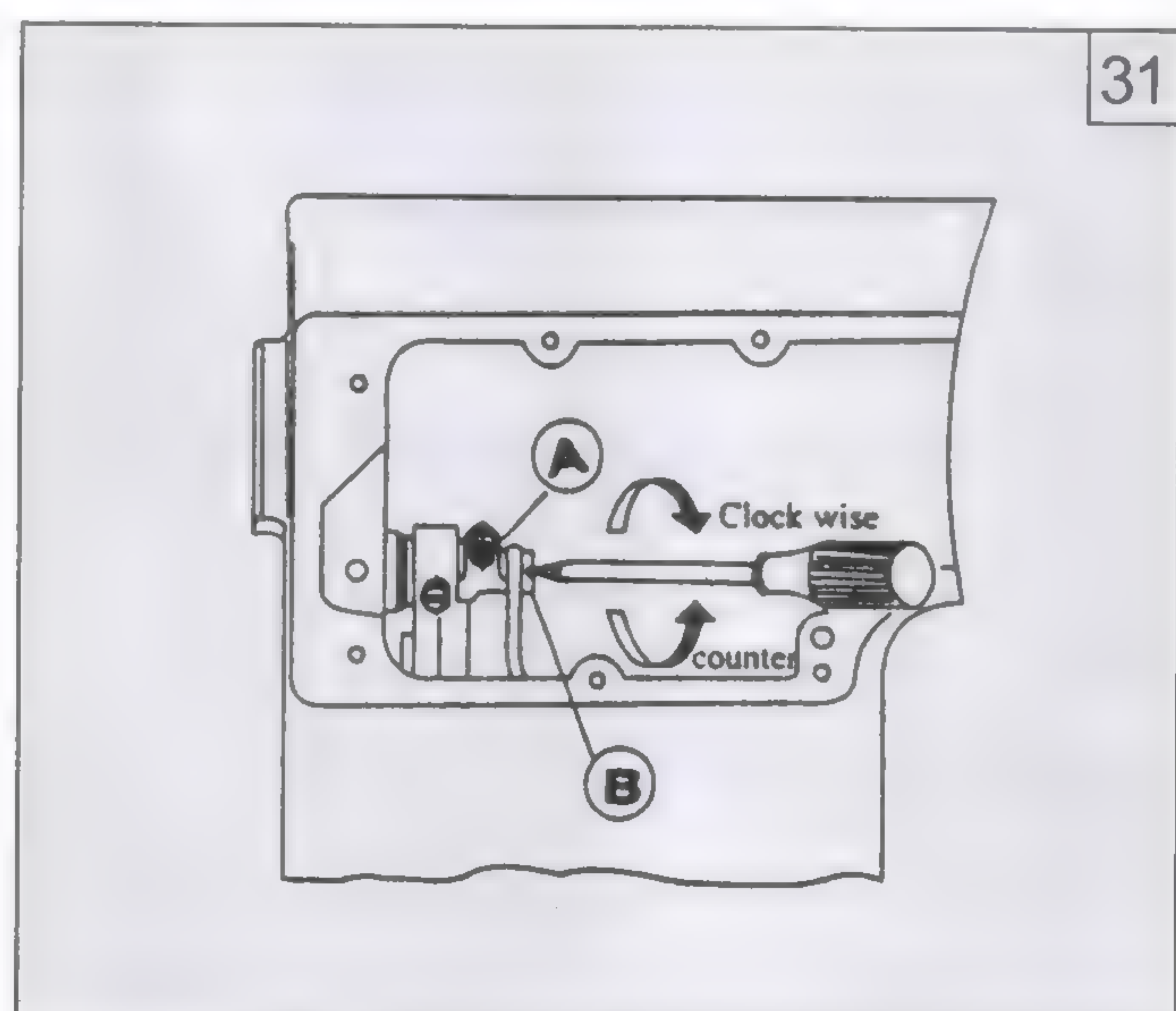


25. Stitch length error adjustment (Fig 31)

Loosen screw (A), and turn stitch length adjusting cam (B).

Turn clockwise: forward sewing, stitch length enlarged; reverse sewing, stitch length shorten.

Turn counter-clockwise: forward sewing stitch length shorten; reverse sewing, stitch length enlarged.

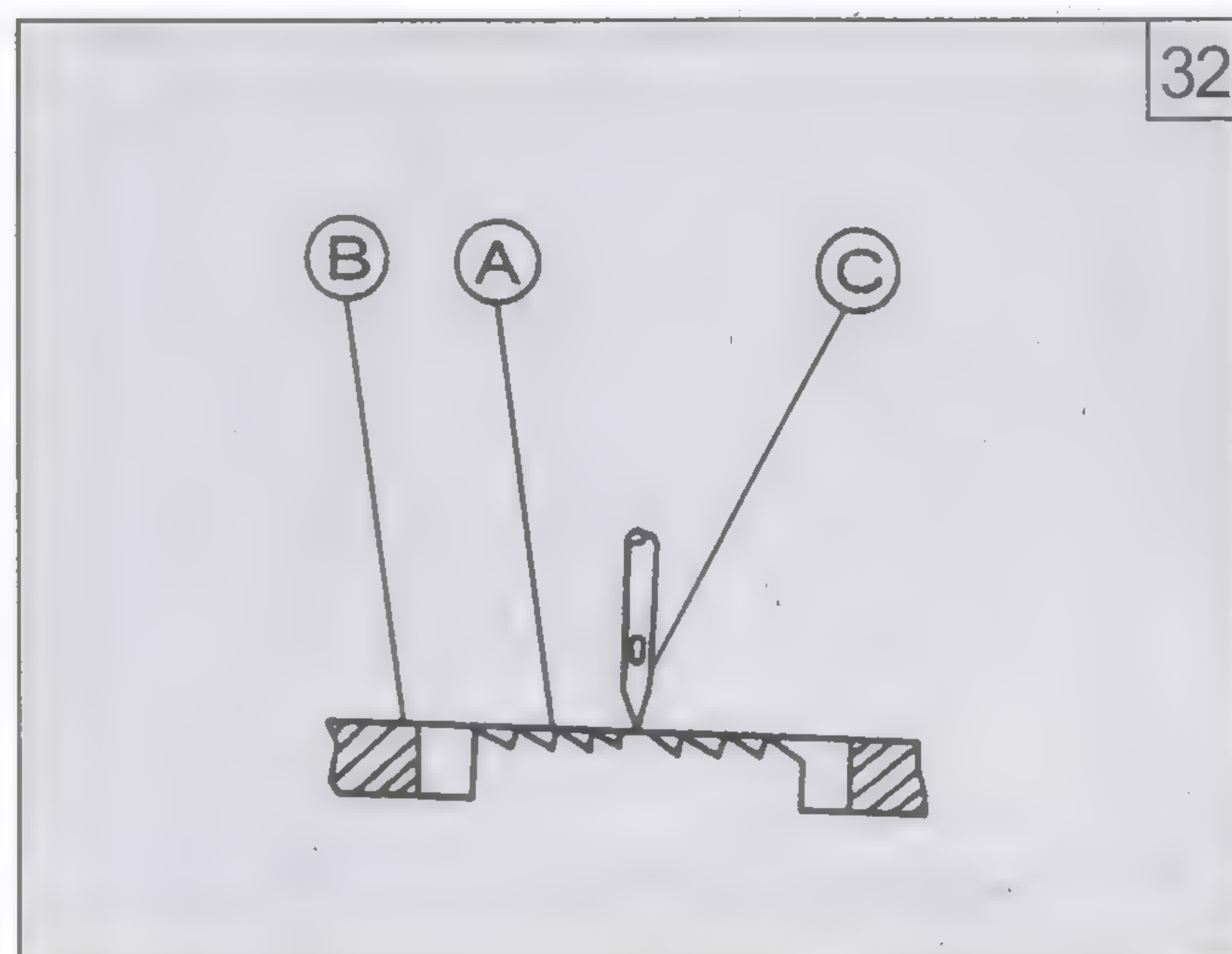


26. Feed timing adjusting (Fig 32 33 34)

1. Standard position

Turn balance wheel to lower Feed dog (A) till it is horizontal with the surface (B) of throat plate, at the moment, the tip of needle (C) should be horizontal with the surfaces of throat plate and feed dog.

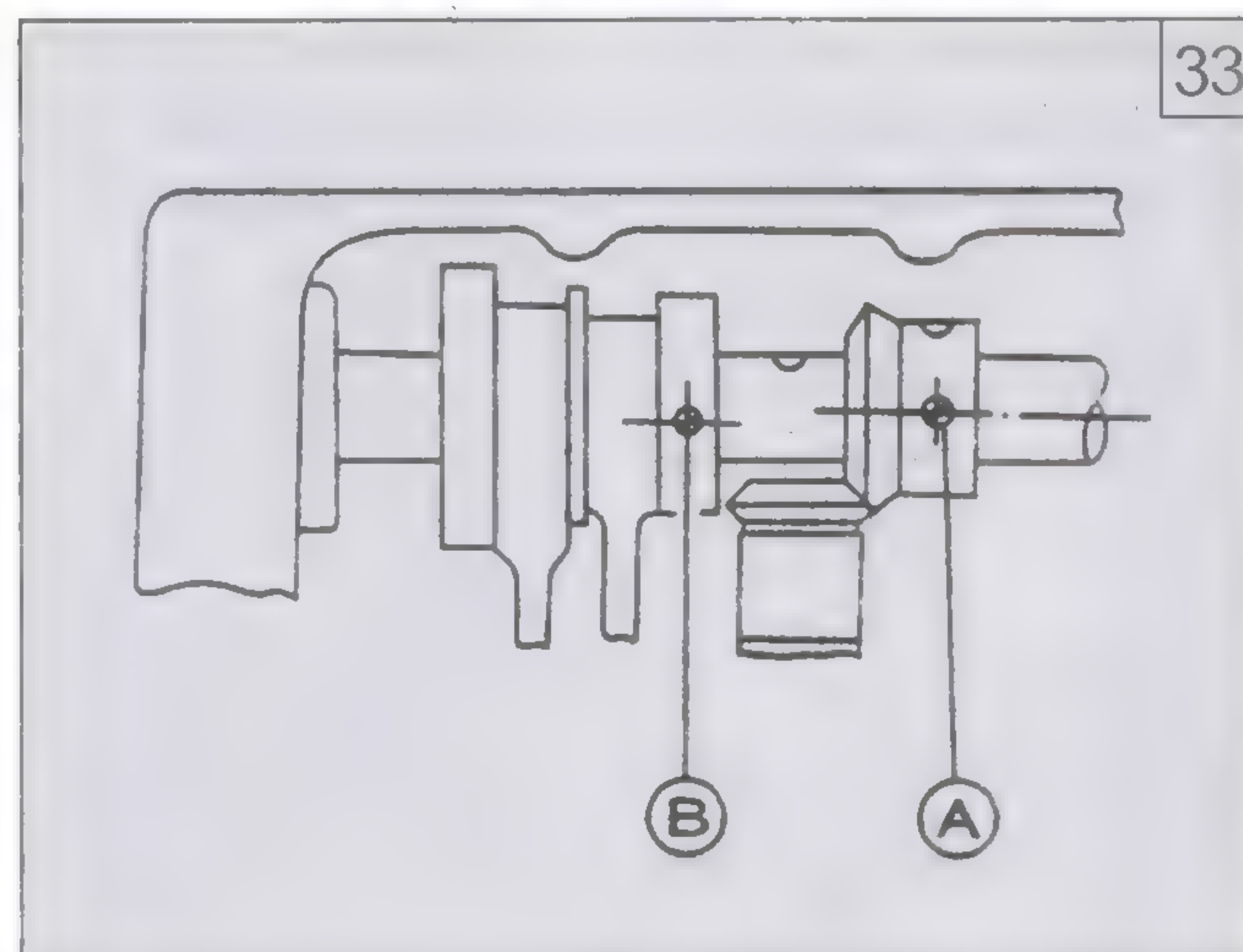
Adjustment can be done by adjusting the position of feed cam and feed dog lift cam.



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2. Installing feed dog lift cam (See Fig 33)

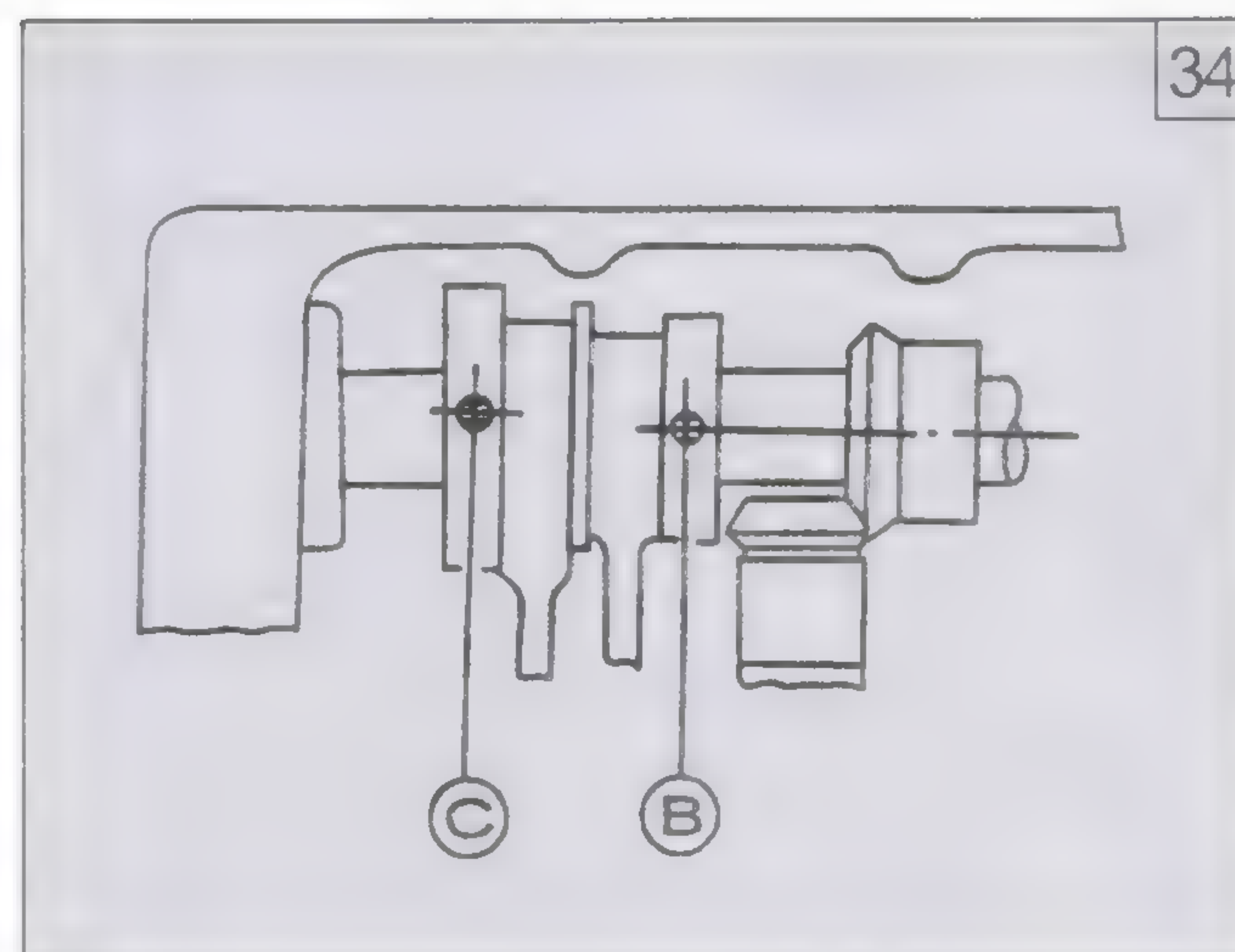
Open the back side cover, turn balance wheel by left hand counter-clockwise, take screw A as for the standard, the center of screw B is slightly a little lower than the center of screw A.



33

3. Installing feed cam (See Fig 34)

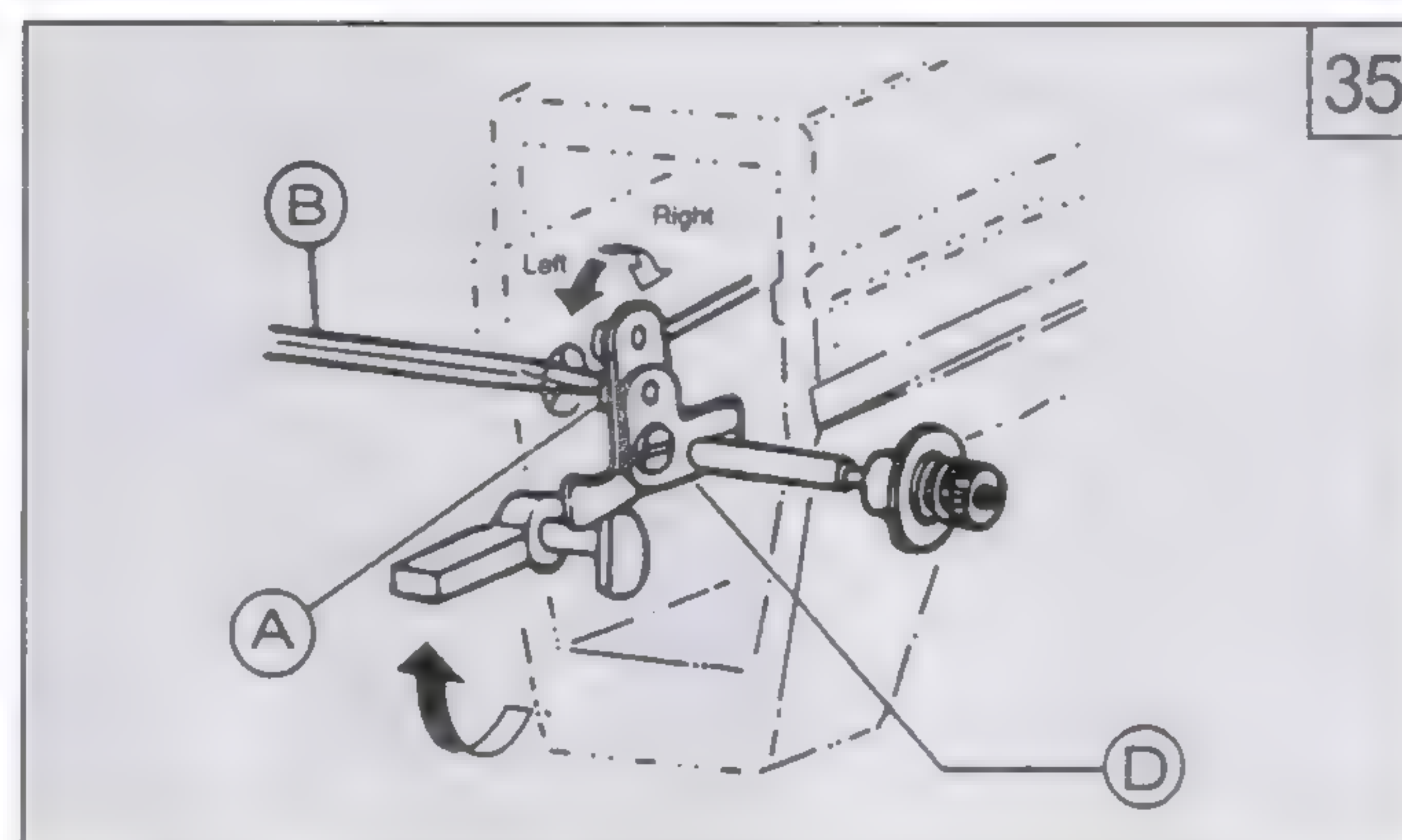
Continuously turn balance wheel, take screw (B) as for standard, the center of screw (C) is slightly a little higher than the center of screw (B).



34

27. Adjusting the tension releasing mechanism (Fig 35)

The tension discs should be pushed apart to open when the presser foot is lifted. But the open timing of the tension discs can be adjusted as follows: Remove face plate and the rubber plug at rear side of arm and loosen screw (A) of the knee lifting lever (left), then the tension releasing cam can be moved leftward or rightward when the cam is moved rightward. it is later to open, otherwise it is earlier to open.

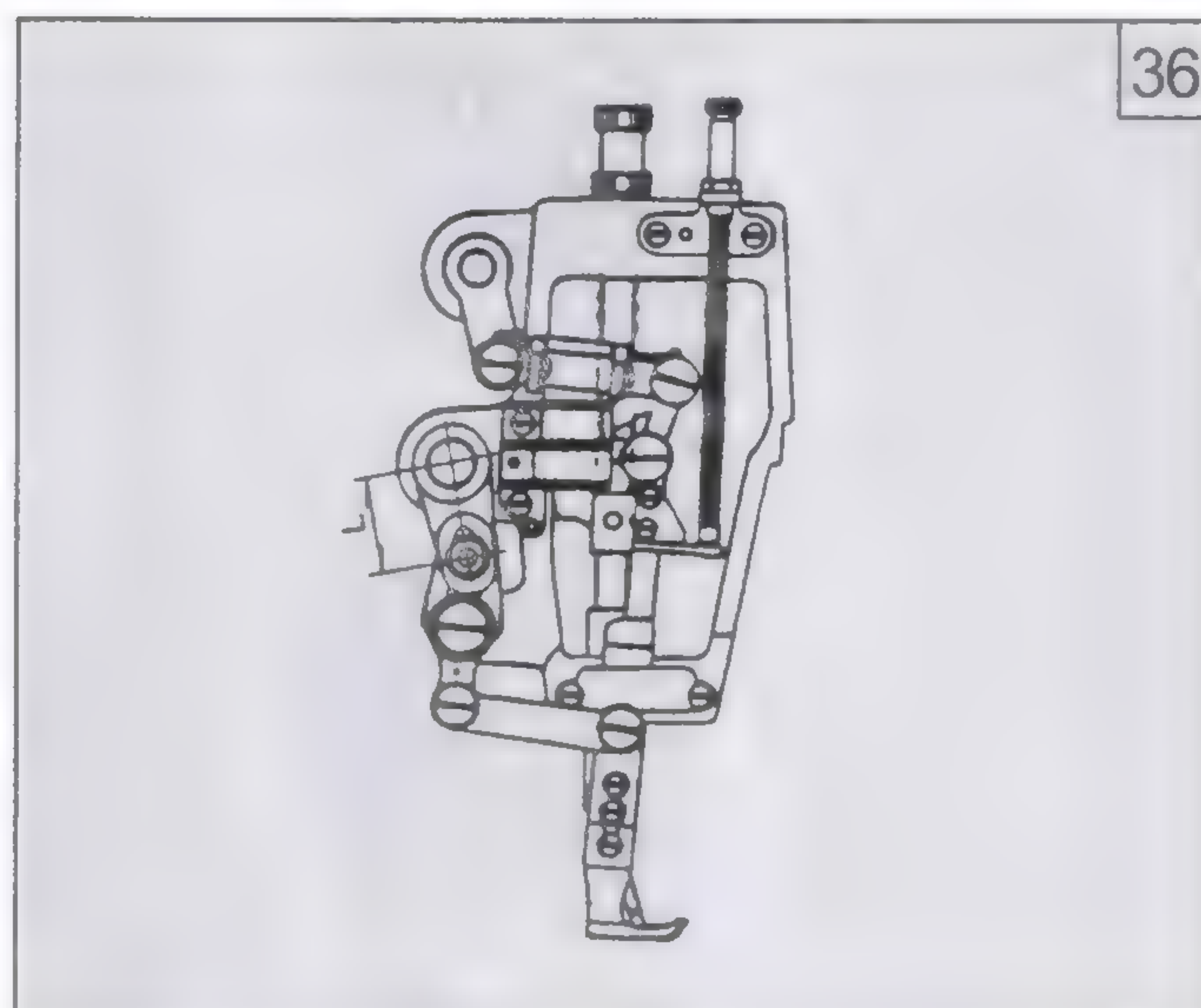


28. Upper feed adjustment (Fig 36)

During the sewing, the center gauge (L) between the walking foot sliding block and its shaft can be adjusted according to the differences of the friction coefficients of materials and the sewing process.

Method: Increase L---the upper feed amount enlarged
reduce L--- the upper feed amount shorten

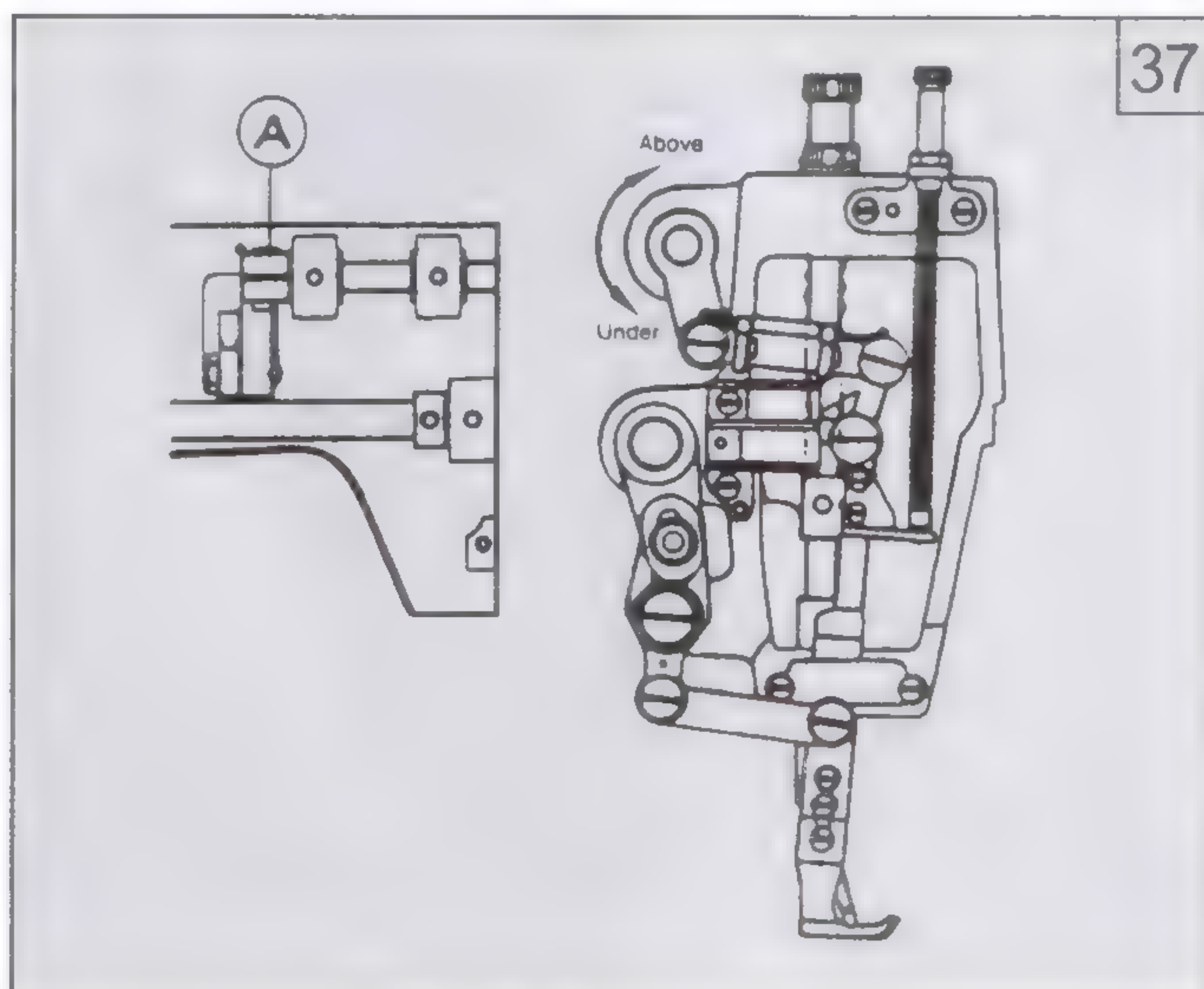
For special sewing requirements, for example, the upper layer of material needs more amount than the lower layer does, in this case, adjustment can be done in the range of above theory for operation.



29. Adjusting presser foot alternate lift mechanism (Fig 37)

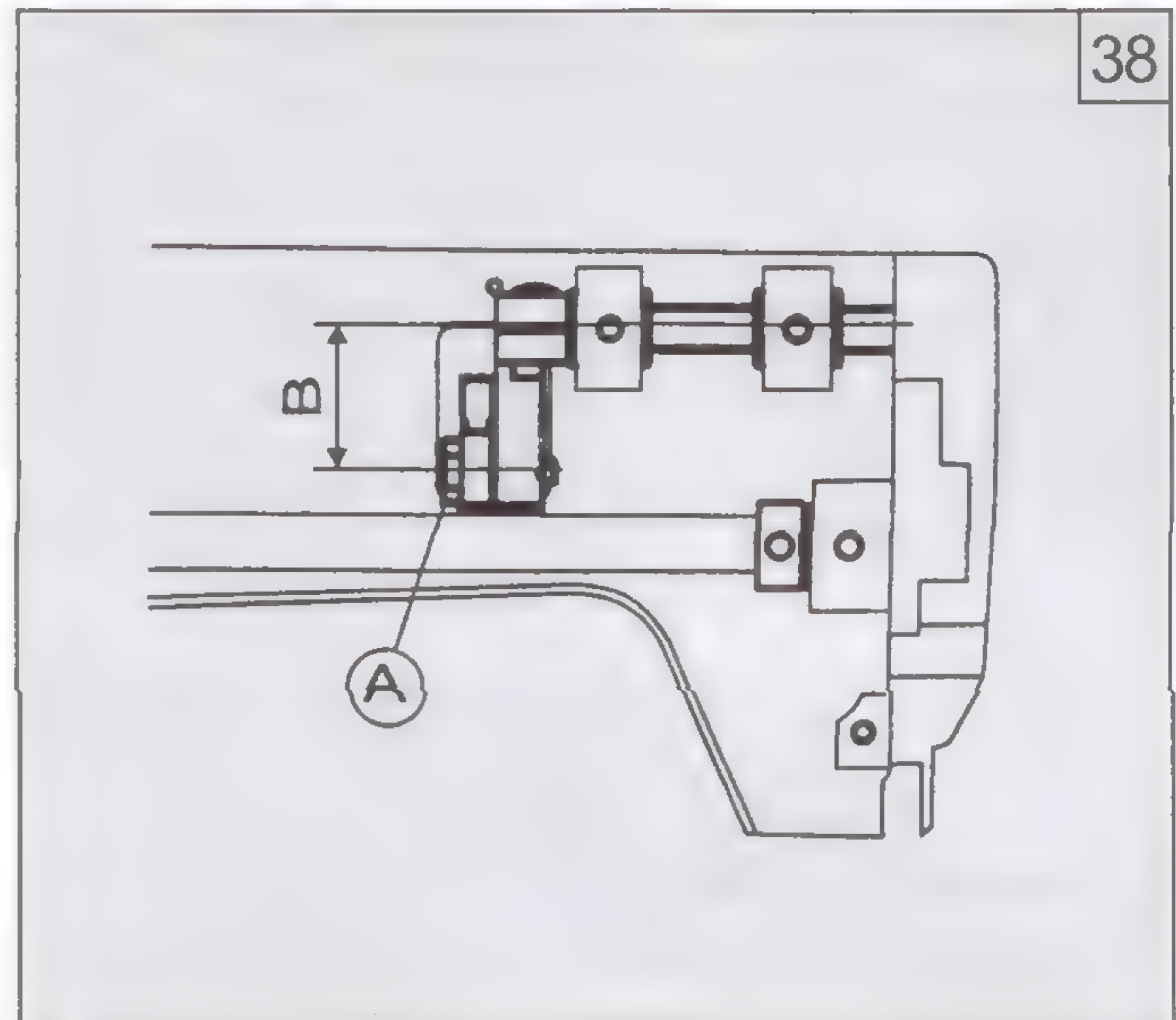
During the sewing, the alternate lift amount can be adjusted according to the nature of material. In general sewing, the amount of walking foot is 5.5mm, and the presser foot lift amount is 3.5mm.

Method: loosen the screw A. turn presser foot front crank up ward to increase the amount of walking foot, turn it downward to reduce the presser foot amount, the range of adjusting amount is not too large. After adjustment, tighten the screw.



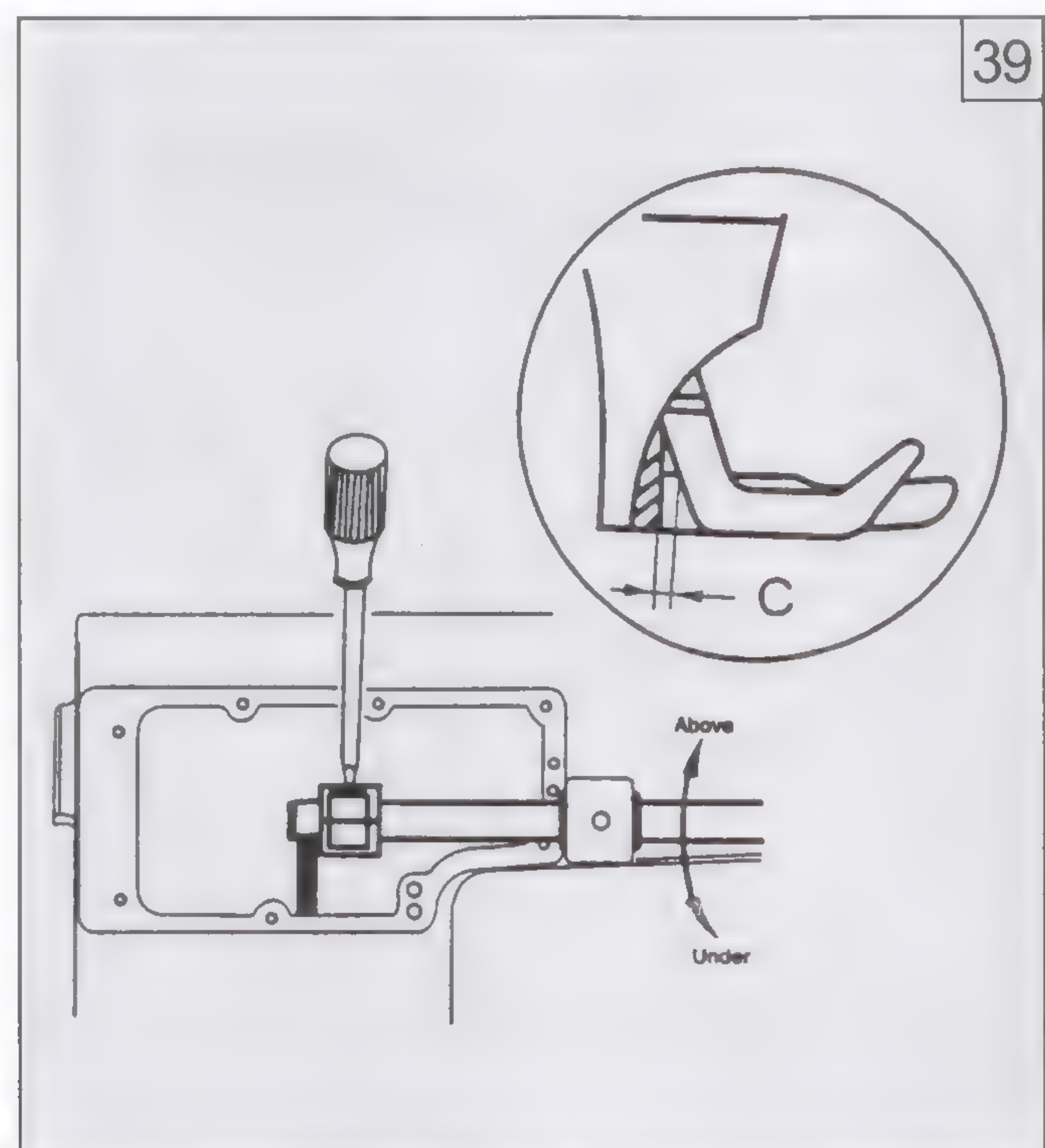
30. Adjusting the lift amount of presser foot together with walking foot (Fig 38)

The lift amount of walking presser foot together with presser foot can also be adjusted slightly. When adjusting, loosen screw (A) adjust its center distance B between the screw (A) and the presser foot lift shaft. The lift amount is increased as to shorten the center distance B, and the lift amount is decreased as to widen the center distance B. After adjustment, tighten the nut again.



31. Adjusting the clearance between presser foot and walking foot (Fig 39)

In sewing operation, for preventing the walking foot from striking on presser foot a proper clearance C of approx. 1.5mm should be maintained between them. When the clearance is too small or too big, necessary to adjust, loosen rear crank screw and turn the rock shaft, then the walking foot moves near the needle bar. When adjust, be sure to note the fixed number of the clearance C.

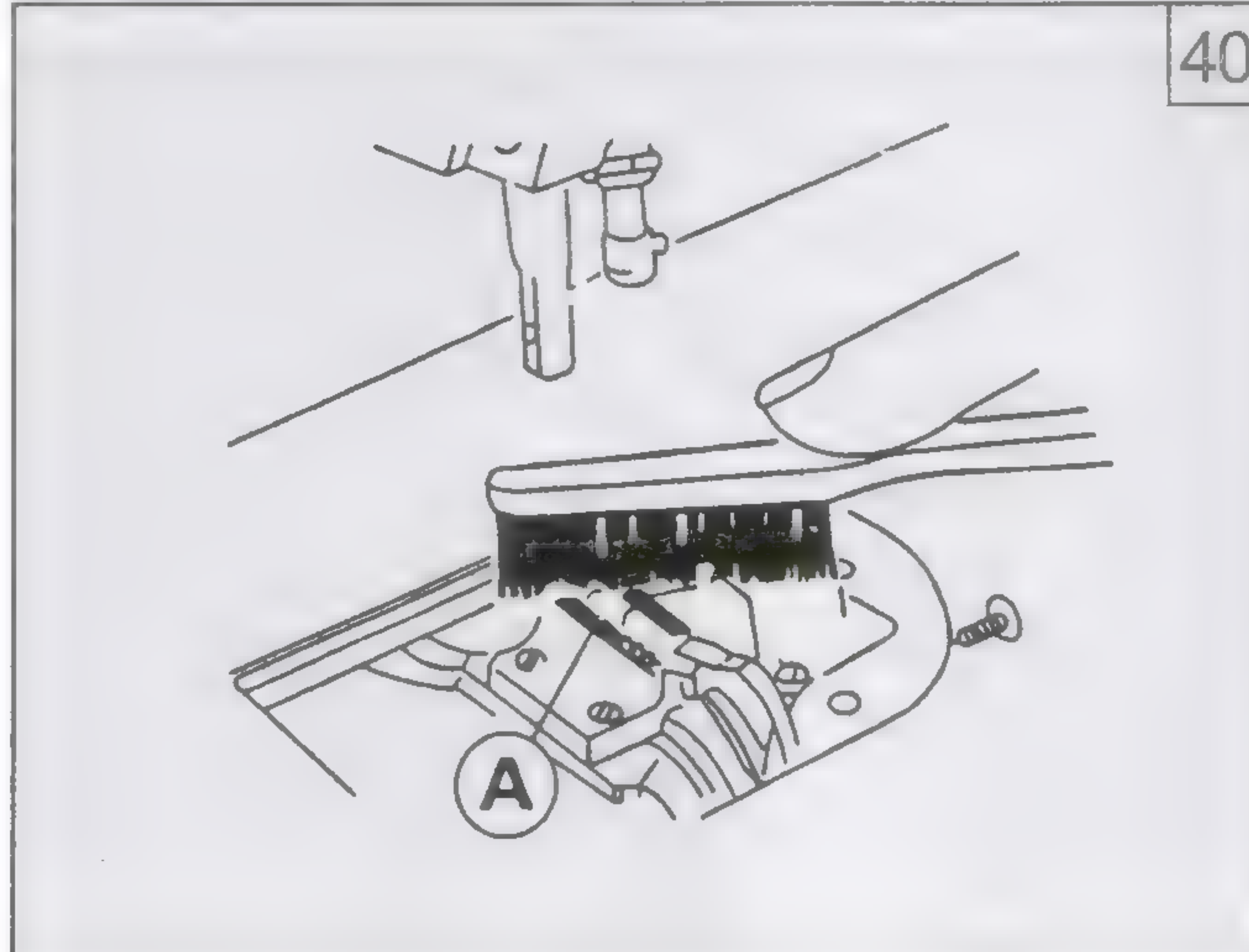


32. Periodical cleaning (Fig 40 41 42)

Clean the feed dog, the rotating hook, the bobbin case, the oil pump, filter screen and the like periodically according to customer's usage.

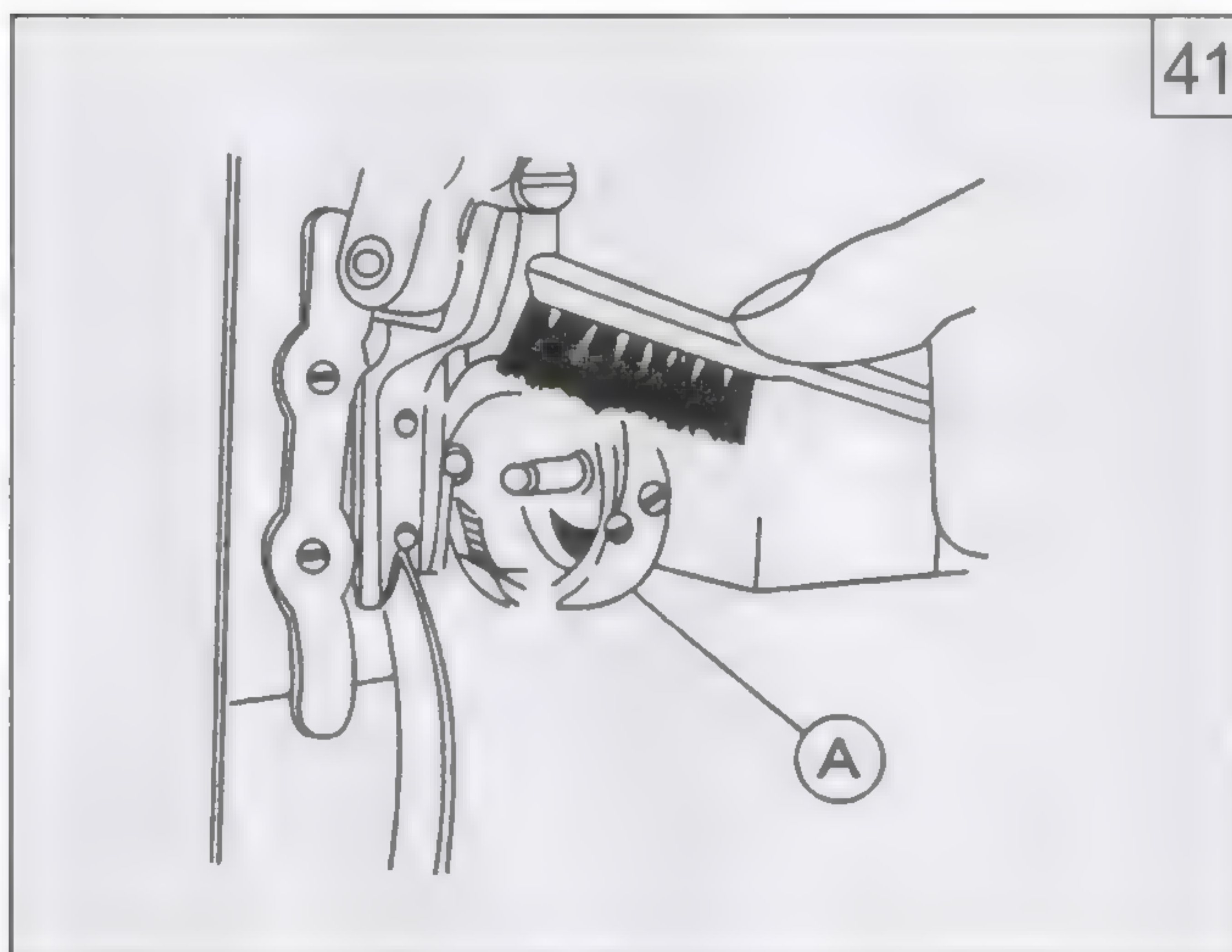
1. Cleaning the feed dog

Remove the throat plate, clean off all the dust and lint on the slit of the feed dog (A), then install the throat plate.



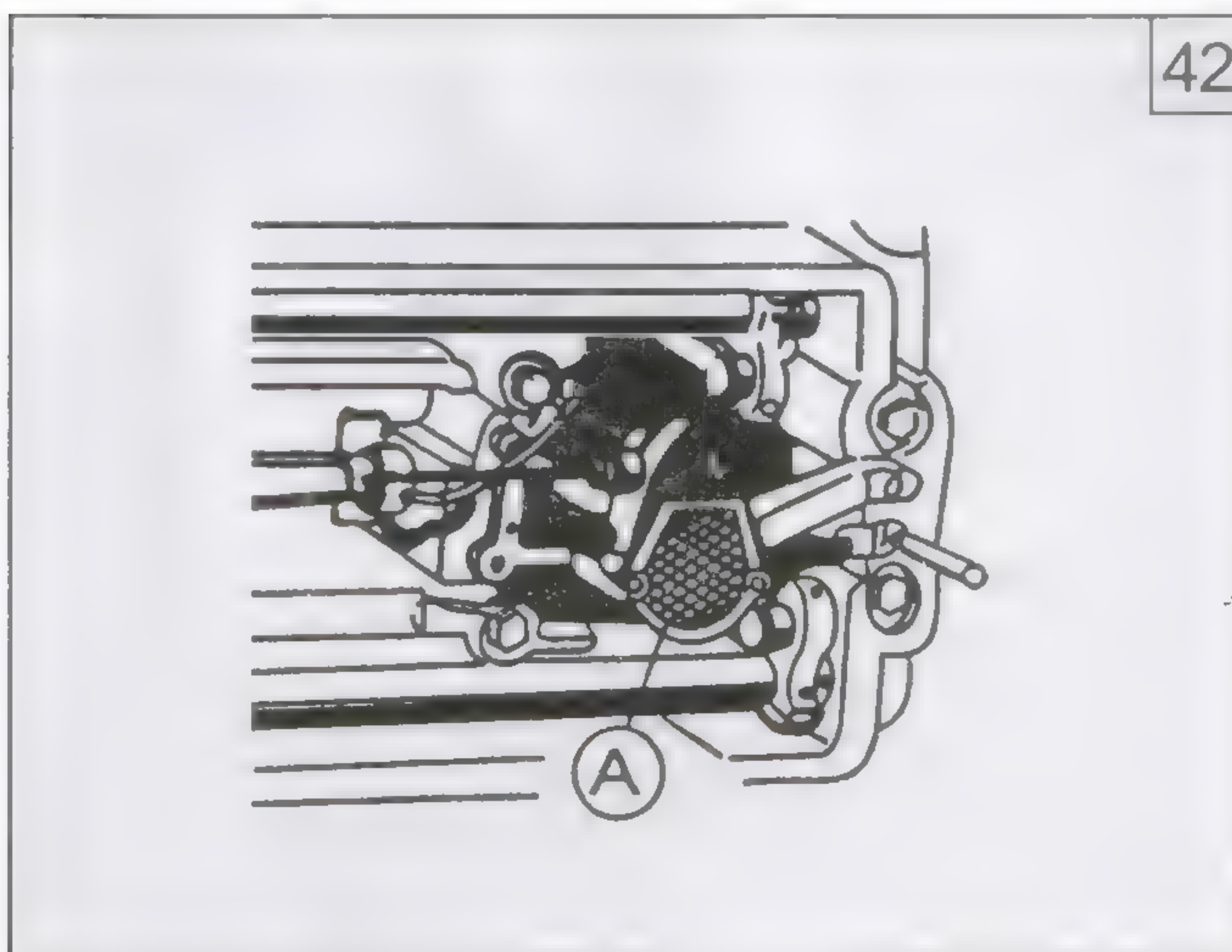
2. Cleaning the rotating hook

Clean off all the dust around the rotating hook (A) and clean the bobbin case with soft cloth.



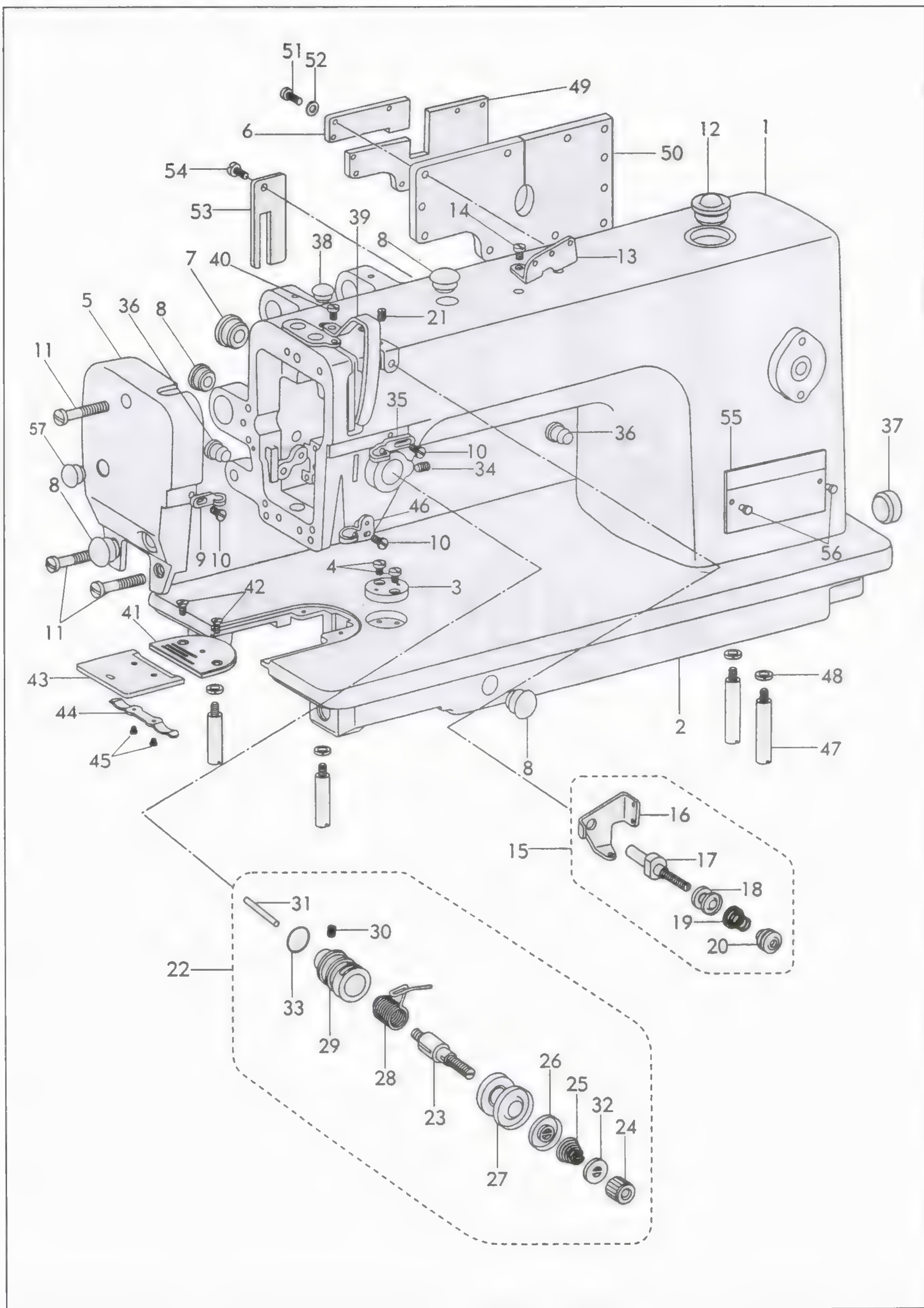
3. Cleaning the oil filter

Take off the oil filter, clean off the dust of filter screen (A) with gasoline.



Parts Manual

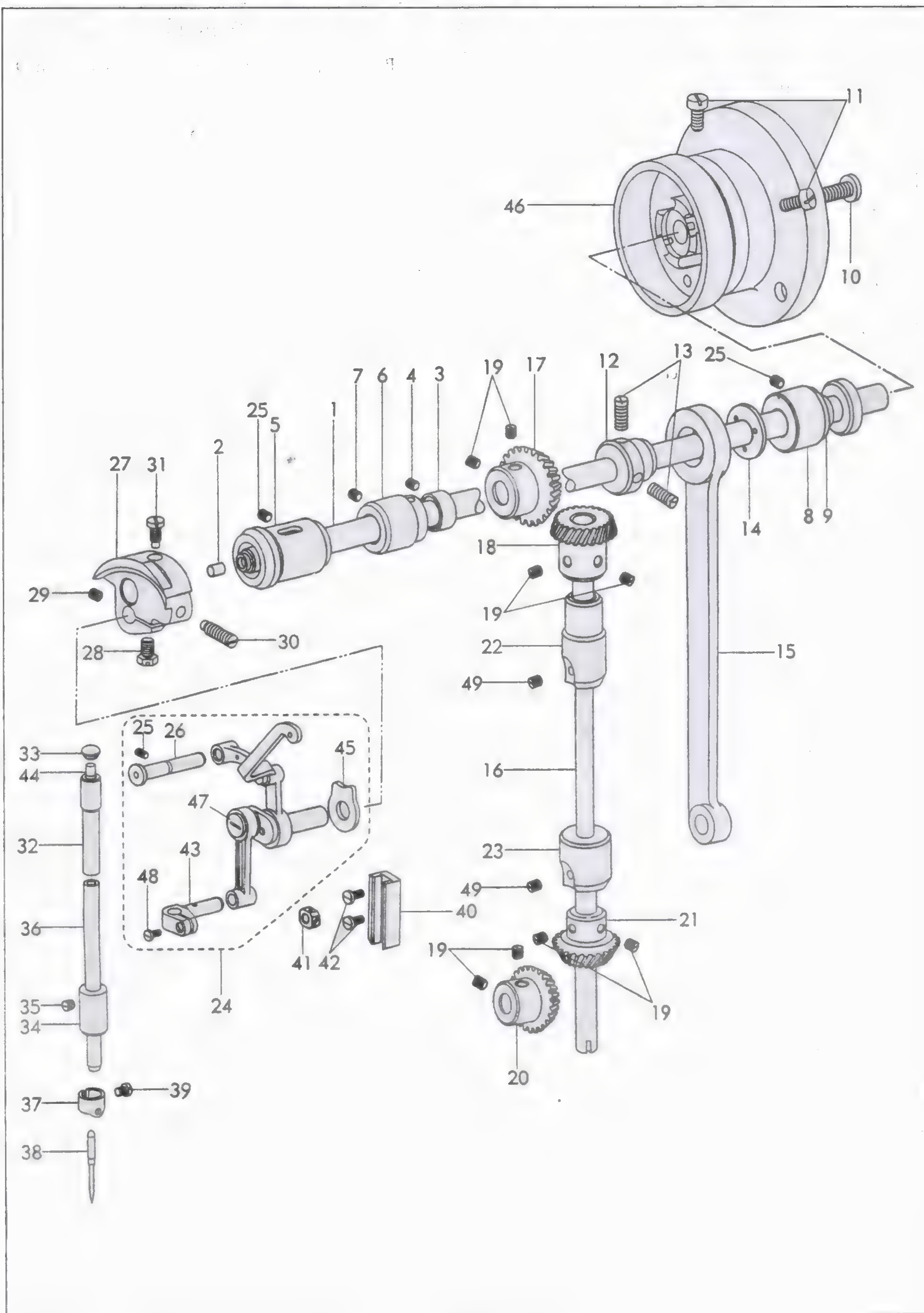
A. Machine Arm and Bed



A. Machine Arm and Bed

No.	Name	Qt.	Remark
A01	Arm	1	Part number shown in parentheses is for JK-6320CX
A02	Bed	1	
A03	Holder	1	
A04	Screw	2	GB827-86 2.5x5
A05	Face plate	1	
A06	Rear cover(small)	1	
A07	Rubber plug(ø19)	1	
A08	Rubber plug(ø11.8)	4	
A09	Thread finger	1	
A10	Screw	3	
A11	Screw	3	
A12	Oil screen complete	1	
A13	Three-eye finger	1	
A14	Screw	1	
A15	Thread tension complete	1	
A16	Thread pass-by plate	1	
A17	Screw	1	
A18	Tension disc	2	
A19	Spring	1	
A20	Nut	1	
A21	Set screw	1	
A22	Thread tension complete	1	
A23	Screw	1	
A24	Nut	1	
A25	Spring	1	
A26	Thread tension complete	1	
A27	Thread tension disc	2	
A28	Thread take-up spring	1	
A29	Thread tension adjusting bracket	1	
A30	Screw	1	
A31	Thread releasing pin	1	
A32	Stopping plate	1	
A33	O-type ring	1	
A34	Set screw	1	
A35	Thread finger	1	
A36	Rubber plug(ø 8.8)	2	
A37	Rubber plug(ø 27)	1	
A38	Rubber plug(ø 5.7)	1	
A39	Thread take-up lever guard	1	
A40	Screw	1	
A41	Throat plate	1	
A42	Screw	2	
A43	Sliding plate	1	
A44	Spring	1	
A45	Screw	2	
A46	Lower thread finger	1	
A47	Bed leg	4	
A48	Washer	4	
A49	Rear cover	1	Washer GB93-87
A50	Seal gasket	1	
A51	Screw	10	
A52	Washer	10	
A53	Oil retaining plate	1	
A54	Screw	1	
A55	Trade mark plate	1	Part number shown in parentheses is for JK-6320CX
A56	Rivet	2	
A57	Rubber plug(ø19)	1	

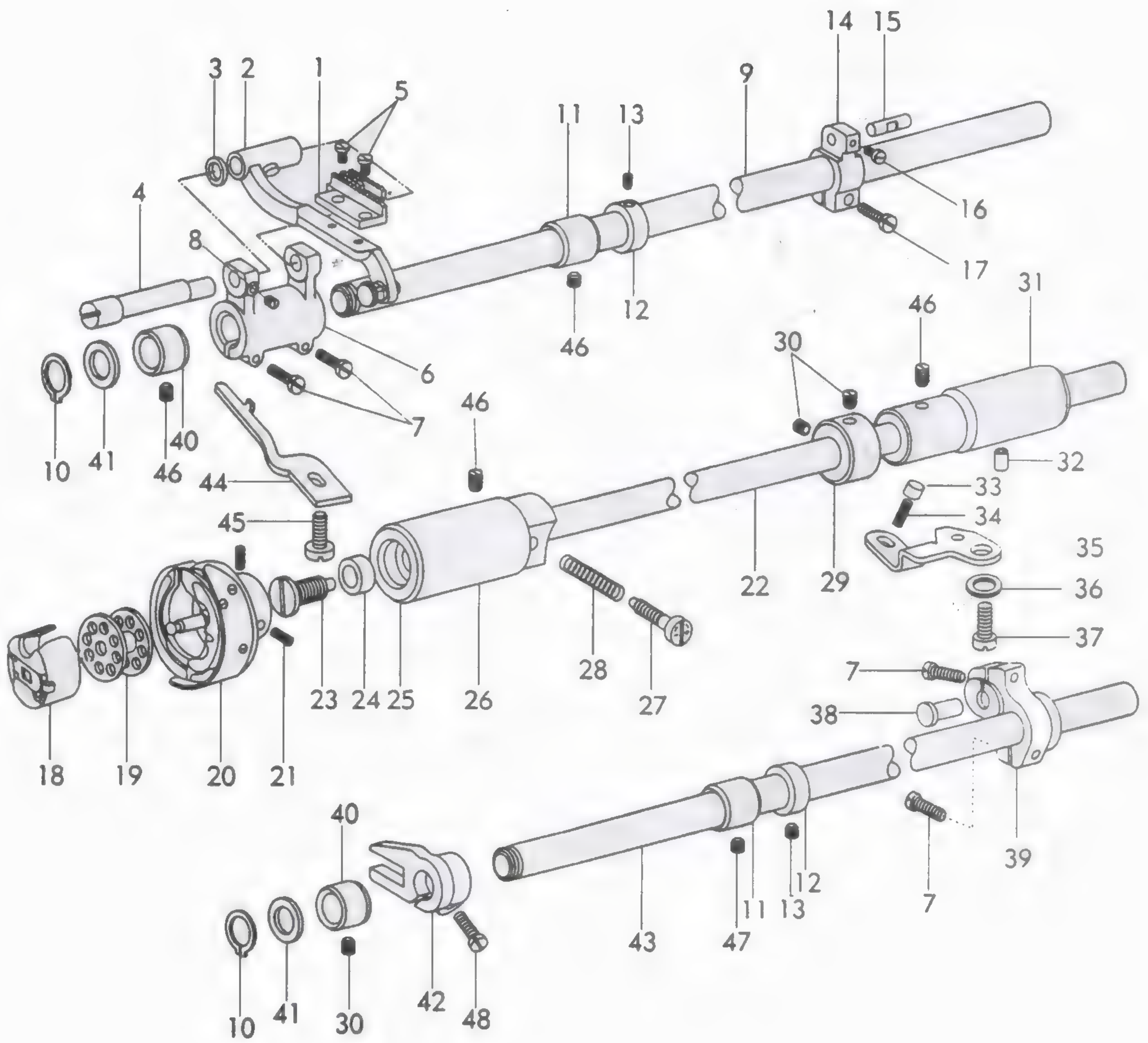
B. Arm Shaft and Vertical Shaft Needle bar Thread Take-up



B. Arm Shaft and Vertical Shaft Needle bar Thread Take-up

No.	Name	Qt.	Remark
B01	Arm shaft	1	
B02	Rubber plug	2	
B03	Collar	1	
B04	Screw	2	
B05	Front bushing	1	
B06	Middle bushing	1	
B07	Screw	1	
B08	Rear bushing	1	
B09	Oil seal complete	1	
B10	Screw	1	
B11	Screw	2	
B12	Feed dog lift cam	1	
B13	Screw	3	
B14	Seperating piece for cam	1	
B15	Link	1	
B16	Vertical shaft	1	
B17	Bevel gear	1	
B18	Vertical shaft bevel gear(upper)	1	
B19	Screw	8	
B20	Rock shaft bevel gear	1	
B21	Vertical shaft bevel gear(lower)	1	
B22	Vertical shaft bushing(upper)complete	1	
B23	Vertical shaft bushing(lower)complete	1	
B24	Thread take-up lever complete	1	
B25	Screw	3	
B26	Hinge pin	1	
B27	Needle bar crank	1	
B28	Screw	1	
B29	Set screw	1	
B30	Screw	1	
B31	Set screw	1	
B32	Needle bar upper bushing	1	
B33	Rubble plug (ø8.8)	1	
B34	Needle bar lower bushing	1	
B35	Screw	1	
B36	Needle bar	1	
B37	Thread finger	1	
B38	Needle	1	DPx17 23" (25" for JK-6320CX)
B39	Screw	1	
B40	Rail	1	
B41	Sliding block	1	
B42	Screw	2	
B43	Needle bar adaptor	1	
B44	Felt	1	
B45	Washer	1	
B46	Balance wheel	1	
B47	Screw	1	
B48	Screw	1	
B49	Screw	2	

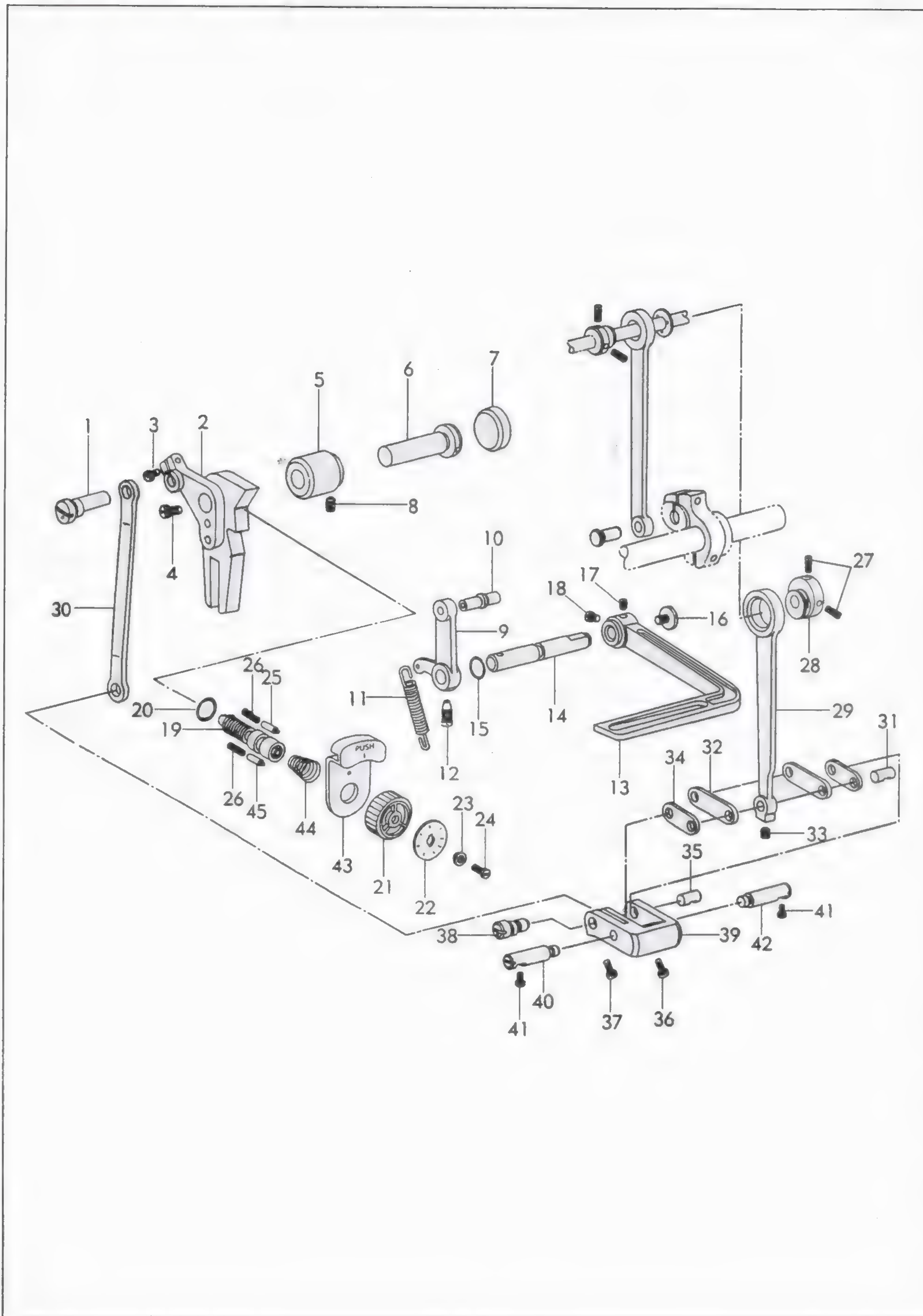
C. Feed Dog Lift And Feed And Thread Looping



C. Feed Dog Lift And Feed And Thread Looping

No.	Name	Qt.	Remark
C01	Feed dog	1	Part number shown in parentheses is for JK-6320CX
C02	Feed dog support complet	1	
C03	Washer	1	
C04	Eccentric shaft	1	
C05	Screw	2	
C06	Feed dog support crank	1	
C07	Screw	4	
C08	Screw	1	
C09	Feed shaft	1	
C10	Stop ring	2	Retainer ring 15 GB894.1-86
C11	Feed shaft middle bushing	2	
C12	Collar	2	
C13	Screw	4	
C14	Feed shaft rear crank	1	
C15	Link pin	1	
C16	Screw	1	
C17	Tension screw	1	
C18	Bobbin case complete	1	Part number shown in parentheses is for JK-6320CX
C19	Bobbin	1	
C20	Hook complete	1	
C21	Hook screw	3	
C22	Rock shaft	1	
C23	Screw	1	
C24	Plug	1	
C25	Oil seal	1	
C26	Front bushing	1	Retainer ring 6 GB93-87
C27	Screw	1	
C28	Spring	1	
C29	Collar	1	
C30	Screw	3	
C31	Rear bushing	1	
C32	Oil tube	1	
C33	Plunge	1	
C34	Spring	1	
C35	Stopper	1	
C36	Washer	1	
C37	Screw	1	
C38	Hinge pin	1	
C39	Feed dog lift rear crank	1	
C40	Feed shaft front bushing	2	
C41	Washer	2	
C42	Feed dog lift fork	1	
C43	Shaft for feed dog lift fork	1	
C44	Hook set bracket	1	
C45	Screw	1	
C46	Screw	4	
C47	Screw	1	
C48	Screw	1	

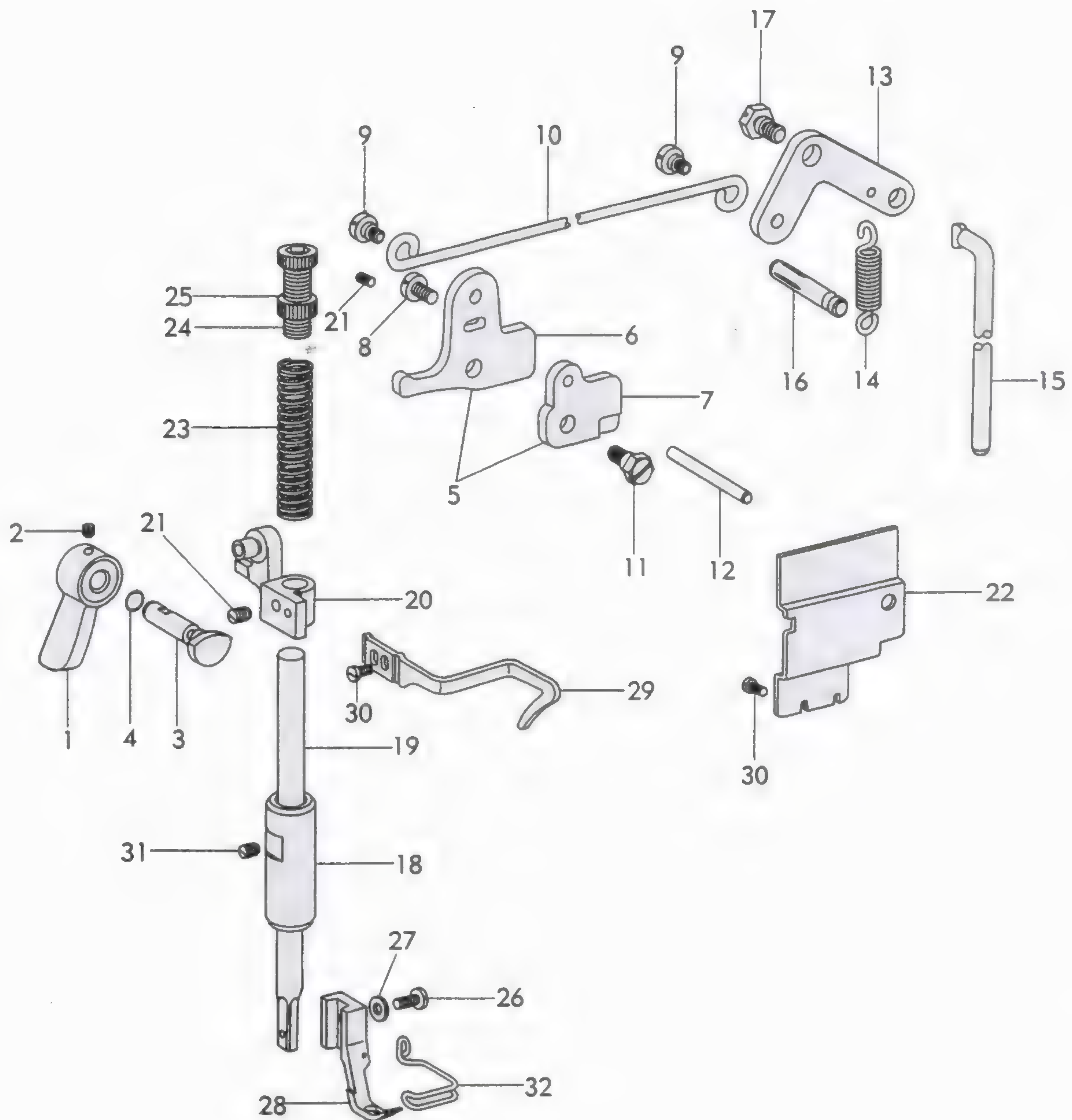
D. Feed Mechanism



D. Feed Mechanism

No.	Name	Qt.	Remark
D01	Link pin	1	
D02	Stitch length bracket	1	
D03	Screw	1	
D04	Screw	1	
D05	Bushing	1	
D06	Shaft for stitch length bracket	1	
D07	Rubber plug (ø20)	1	
D08	Set screw	1	
D09	Reverse feed lever crank	1	
D10	Shaft for block	1	
D11	Spring	1	
D12	Screw	1	
D13	Reverse feed lever	1	
D14	Pin shaft	1	
D15	O-type ring	1	O-type ring 6.3x1.8G GB3452.1-92
D16	Tension screew	1	
D17	Set screw	1	
D18	Screw	1	
D19	Screw bolt for stitch length	1	
D20	O-type rubber ring	1	O-type ring 14x2.4
D21	Dial cup	1	
D22	Dial face	1	
D23	Screw bushing	1	
D24	Screw	1	
D25	Stop pin	1	
D26	Spring	2	
D27	Screw	3	
D28	Feed cam	1	
D29	Feed link	1	
D30	Stitch adjusting link	1	
D31	Pin	1	
D32	Link	2	
D33	Screw	1	
D34	Link	2	
D35	Pin for link	1	
D36	Screw	1	
D37	Screw	1	
D38	Link eccentric shaft	1	
D39	Stitch lenbgth adjusting crank	1	
D40	Set pin(left)	1	
D41	Screw	2	
D42	Set pin(right)	1	
D43	Push lever	1	
D44	Spring	1	
D45	Pin	1	

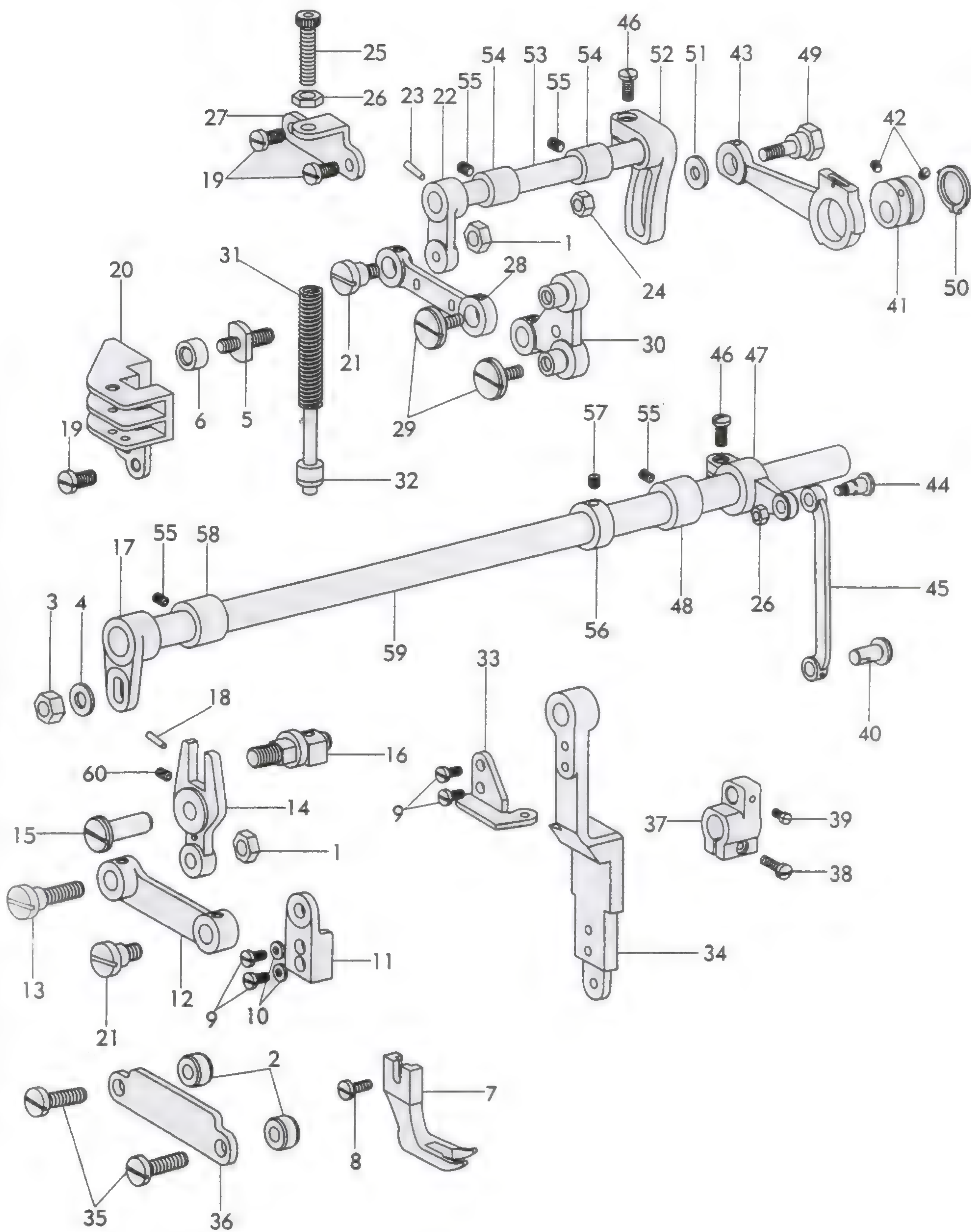
E. Presser Foot



E. Presser Foot

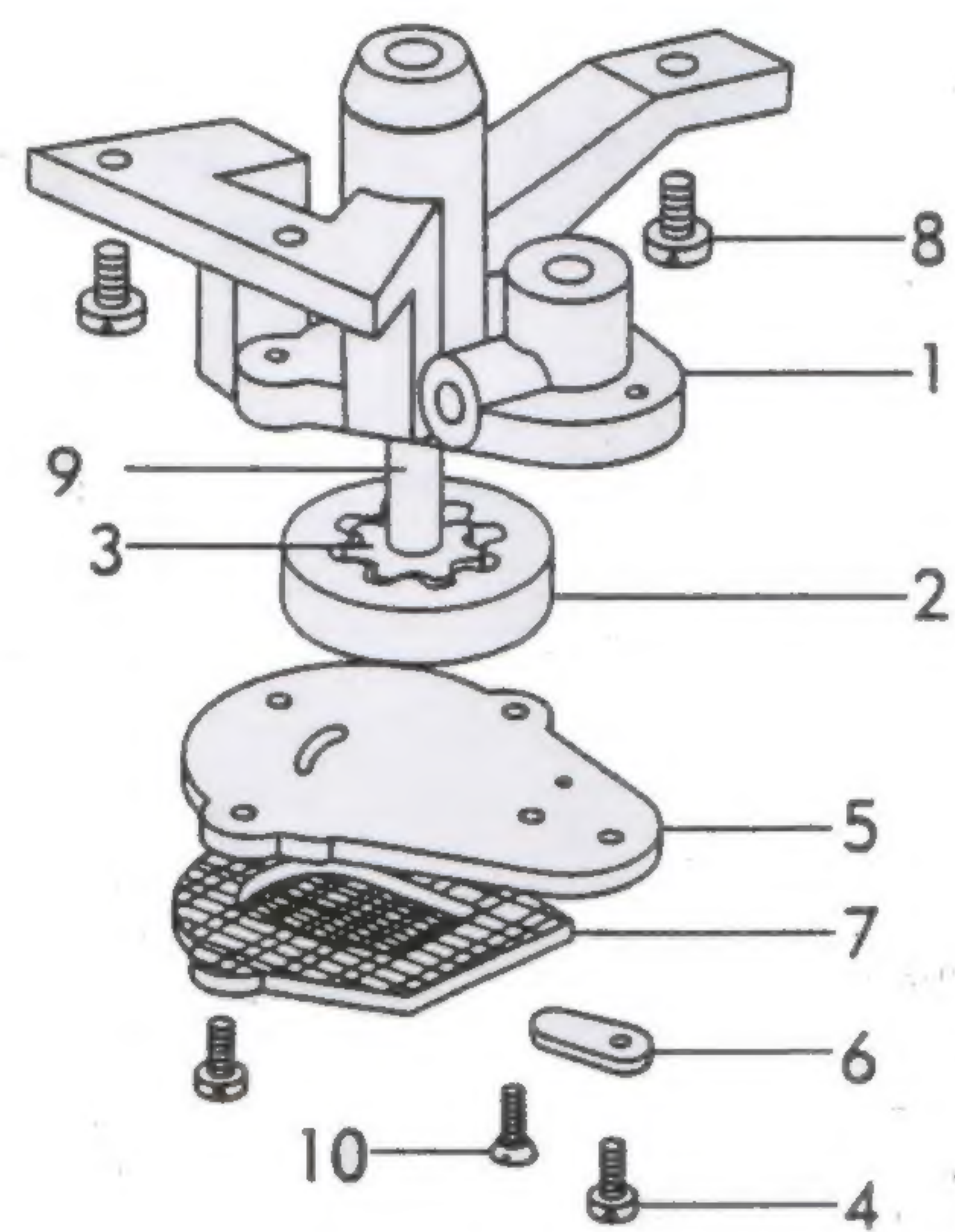
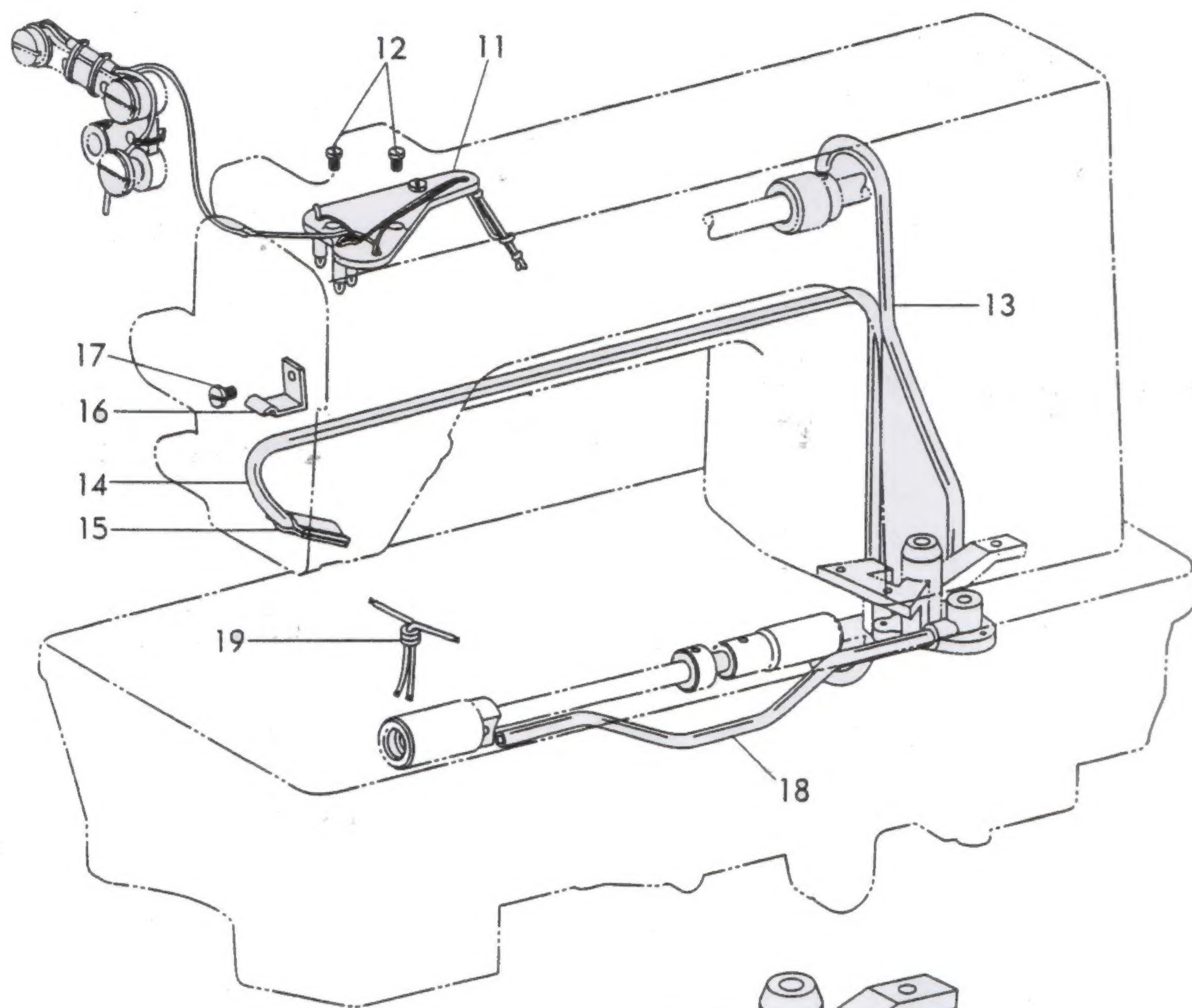
No.	Name	Qt.	Remark
E01	Presser foot lift bar	1	O-type ring 5.15x1.8G GB3452.1-92
E02	Screw	1	
E03	Presser bar lift cam	1	
E04	Oil seal	1	
E05	Knee lifter lever(left) complete	1	
E06	Lever (left)	1	
E07	Thread releasing cam	1	
E08	Screw	1	
E09	Screw	2	
E10	Knee lifter drawing bar	1	
E11	Screw	1	
E12	Thread releasing lever	1	
E13	Knee lifter lever(right)	1	
E14	Spring	1	
E15	Connecting rod	1	
E16	Pin	1	
E17	Screw	1	
E18	Bushing for presser bar	1	
E19	Presser bar	1	
E20	Guide for presser bar	1	
E21	Screw	2	
E22	Oil stop Plate	1	
E23	Sping	1	
E24	Screw	1	
E25	Nut	1	
E26	Screw	1	
E27	Washer	1	
E28	Presser foot	1	
E29	Thread guide	1	
E30	Screw	3	
E31	Screw	1	
E32	Finger guard	1	

F. Upper Feed Parts



F. Upper Feed Parts

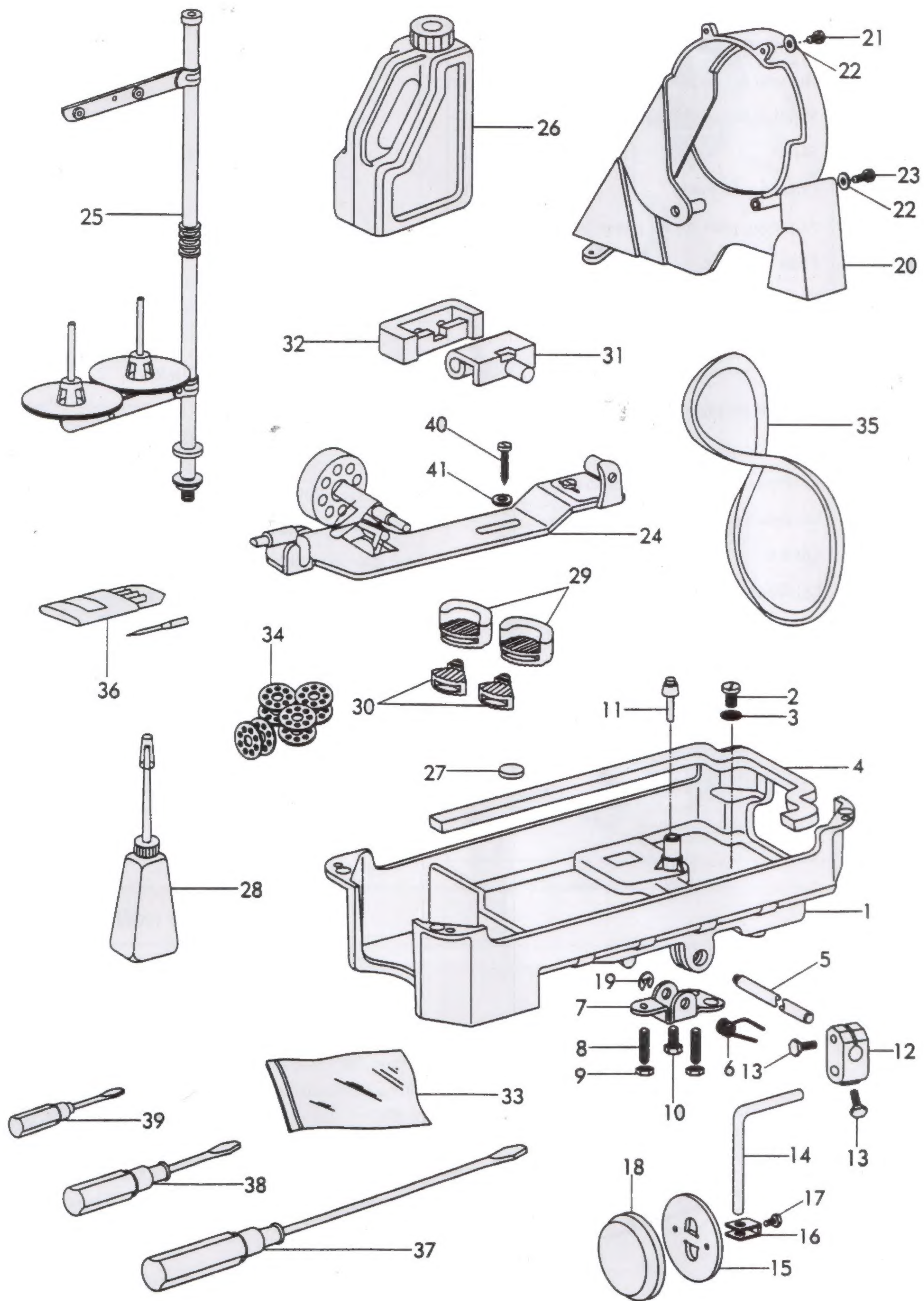
No.	Name	Qt.	Remark
F01	Nut	2	
F02	Shim	2	
F03	Nut	1	
F04	Washer	1	Washer GB95-85-6
F05	Guide shaft	1	
F06	Needle of bearing	1	
F07	Walking foot	1	
F08	Screw	1	
F09	Screw	4	
F10	Washer	2	Washer GB93-87-4
F11	Holder for walking foot bar	1	
F12	Link of walking foot	1	
F13	Screw	1	
F14	Fork lever	1	
F15	Pin	1	
F16	Crank shaft complete	1	
F17	Front crank	1	
F18	Pin	1	Pin GB117-86 A4x24
F19	Screw	4	
F20	Guide plate	1	
F21	Screw	2	
F22	Crank	1	
F23	Pin	1	Pin GB117-86 A4x20
F24	Nut	1	GB50028 M6x0.75
F25	Screw	1	
F26	Nut	2	
F27	Bracket for adjusting screw	1	
F28	Link	1	
F29	Screw	2	
F30	Presser foot feed crank	1	
F31	Spring	1	
F32	Guide pin	1	
F33	Set plate	1	
F34	Walking foot lever	1	
F35	Screw	2	
F36	Presser plate	1	
F37	Feed sheft middle crank	1	
F38	Screw	1	
F39	Pin screw	1	
F40	Connecting pin	1	
F41	Eccentric cam	1	
F42	Screw	2	
F43	Link complete	1	
F44	Screw	1	
F45	Link	1	
F46	Screw	2	
F47	Rear crank	1	
F48	Rear bushing	1	
F49	Screw	1	
F50	Split ring	1	Retainer ring GB894.1-86-25
F51	Washer	1	
F52	Link adjusting crank	1	
F53	Presser foot lift shaft	1	
F54	Bushing	2	
F55	Screw	4	
F56	Collar	1	
F57	Screw	2	
F58	Front bushing	1	
F59	Presser foot swing shaft	1	
F60	Screw	1	



G. Oil Pump

No.	Name	Qt.	Remark
G01	Oil pump	1	
G02	Big gear for oil pump	1	
G03	Small gear for oil pump	1	
G04	Screw	3	M3x10 GB67-85
G05	Cover for oil pump	1	
G06	Adjusting plate for oil pump	1	
G07	Filter complete	1	
G08	Screw for oil pump	3	
G09	Shaft for oil pump	1	
G10	Screw	2	M3x10 GB68-85
G11	Oil wick set plate complete	1	
G12	Screw	2	
G13	Oil pipe complete for upper shaft	1	
G14	Oil return pipe	1	
G15	Oil felt	1	
G16	Oil return pipe clamp	1	
G17	Screw	1	
G18	Oil pipe complete for lower shaft	1	
G19	Oil wick	1	

H. Oil Reservoir and Accessories



H. Oil Reservoir and Accessories

No.	Name	Qt.	Remark
H01	Oil reservoir	1	
H02	Screw	1	
H03	Washer	1	
H04	Gasket	1	
H05	Hinge pin	1	
H06	Spring	1	
H07	Knee lifter stop bracket	1	
H08	Screw	2	
H09	Nut	2	
H10	Screw	1	
H11	Knee lifter prop bar	1	
H12	Connector	1	
H13	Screw	2	
H14	Bent rod	1	
H15	Bell	1	
H16	Bell bracket	1	
H17	Screw	1	
H18	Pat	1	
H19	Split stop ring	1	Stop ring 9 GB896-86
H20	Belt guard complete	1	
H21	Screw (small)	2	GB67-85 M4x8
H22	Washer	2	GB97.1-85-4
H23	Screw (big)	2	GB67-85 M5x12
H24	Thread winder complete	1	
H25	Spool stand complete	1	
H26	Oil tank	1	
H27	Magnet	1	
H28	Oil pot	1	
H29	Cushion (big)	2	
H30	Cushion (small)	2	
H31	Rubber coat	2	
H32	Hinge	2	
H33	Parts bag	1	
H34	Bobbin	5	
H35	V-type belt	1	V-type M39
H36	Needle	1 bag	DPx17 23#(JK-6320CX 25#)
H37	Screw driver (big)	1	
H38	Screw driver (middle)	1	
H39	Screw driver (small)	1	
H40	Wood screw	4	GB5282-85 ST4.8x19
H41	Washer	2	GB95-85-6